

FIG. 1

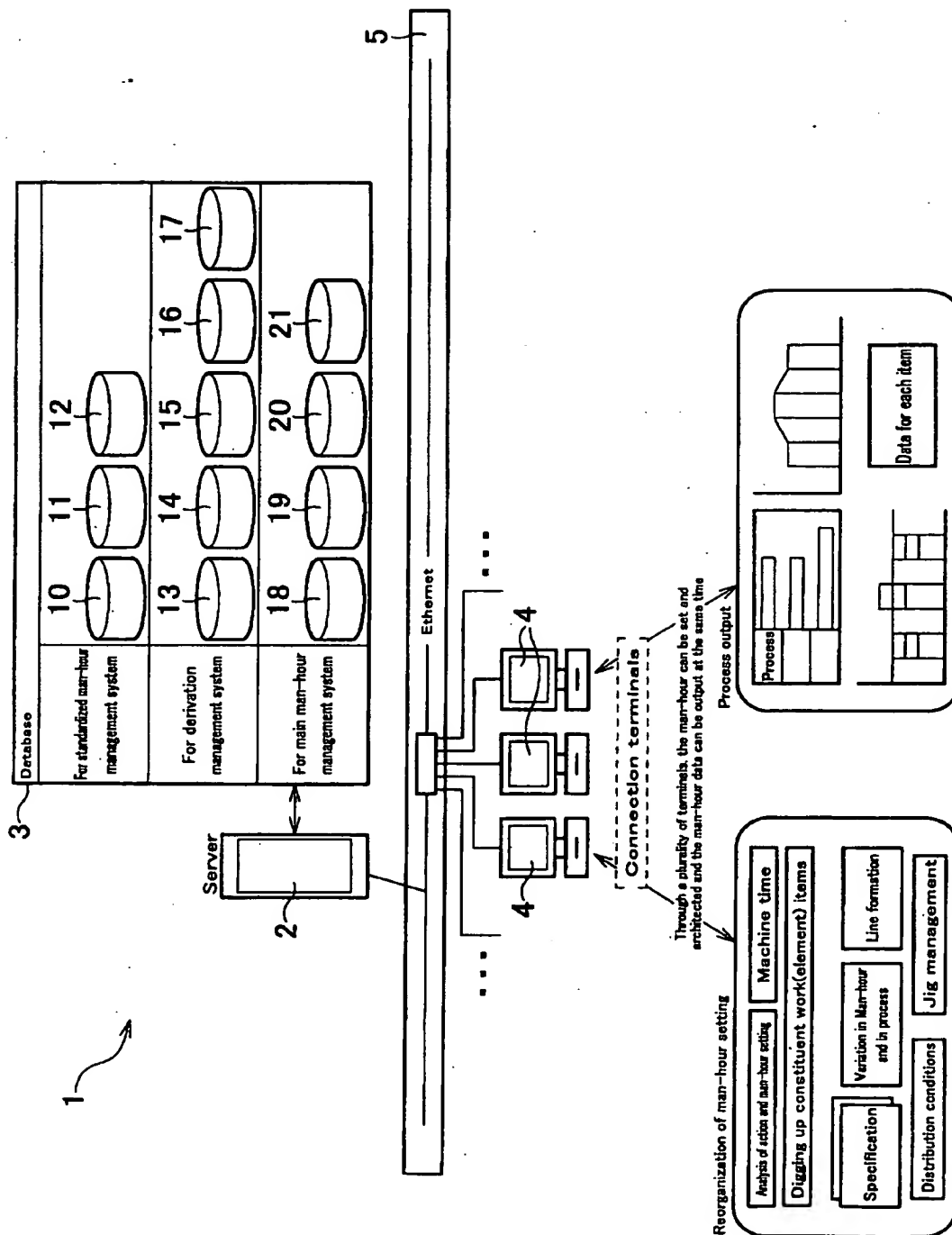
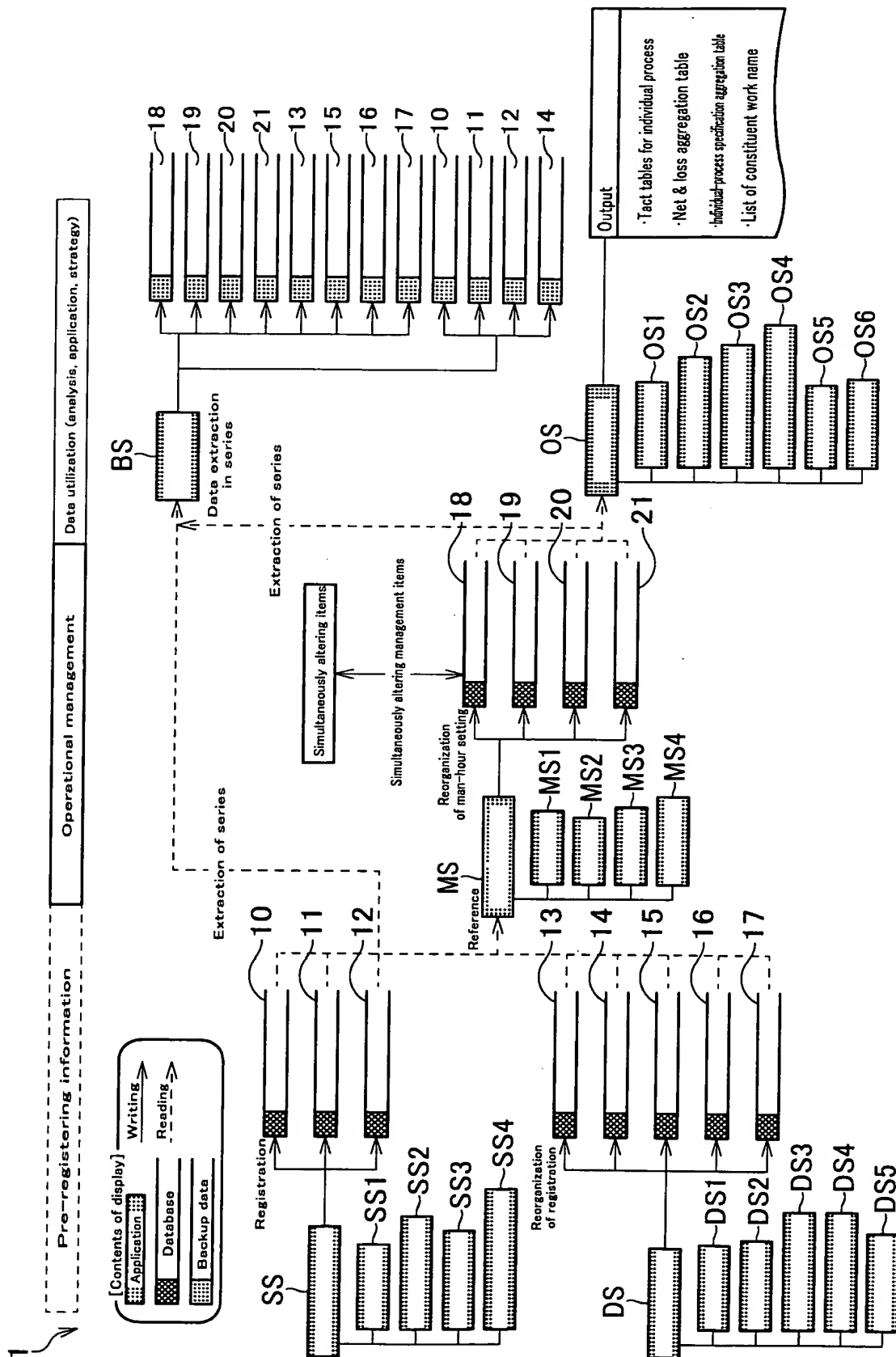


FIG.2



[illegible]

FIG. 4

FIG. 4

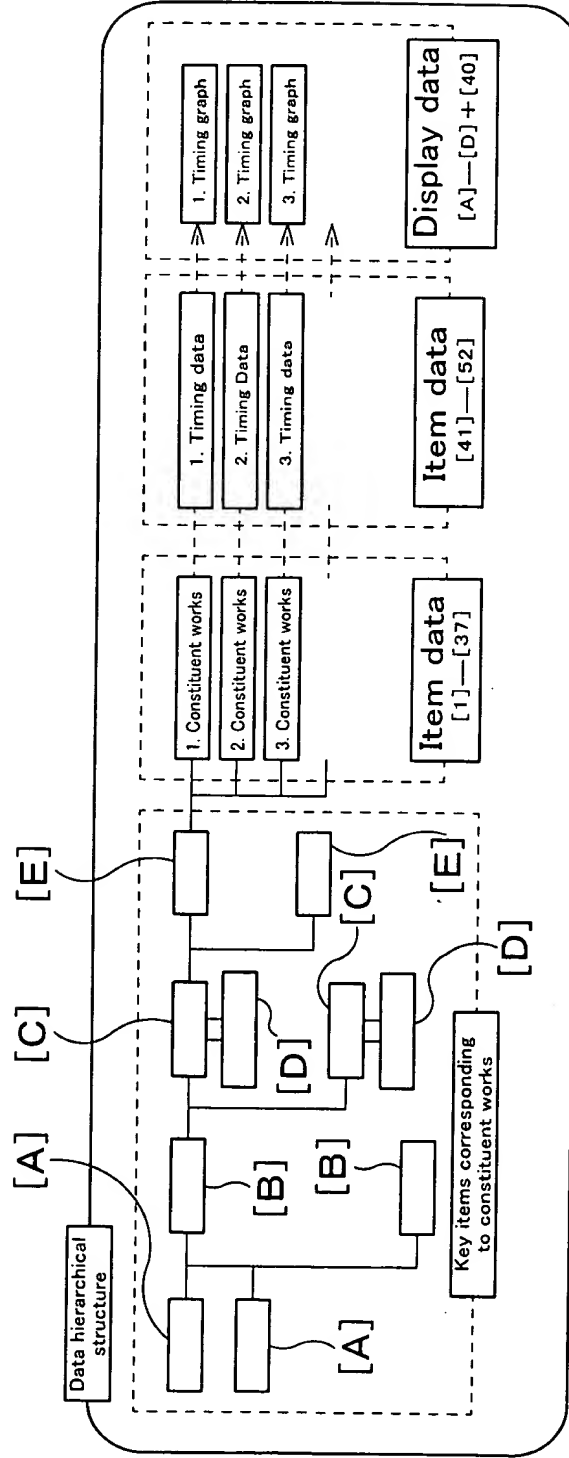


FIG. 5

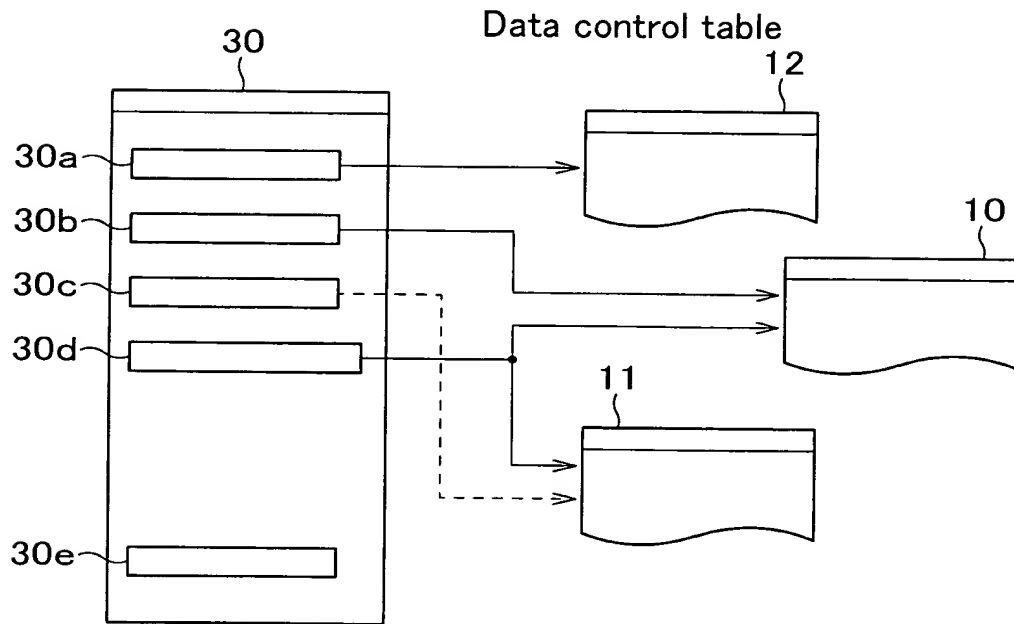


FIG. 6

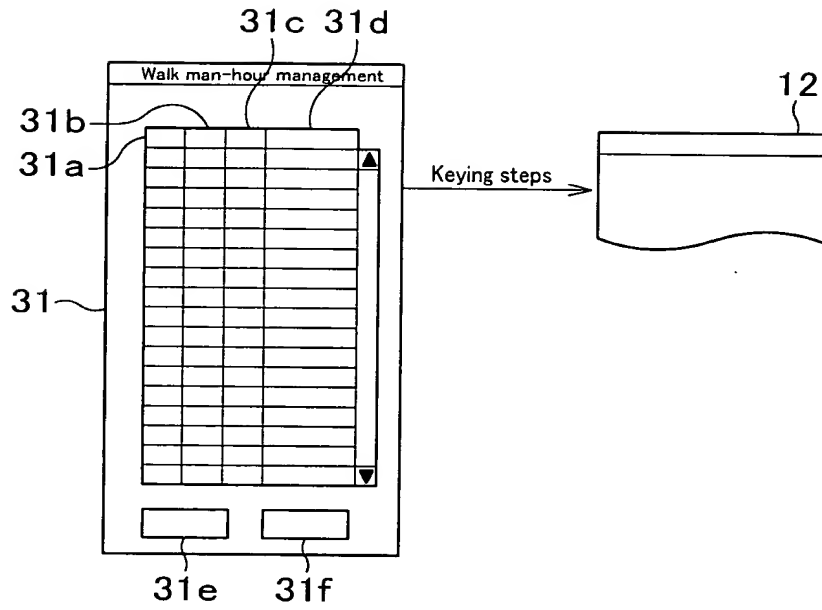


FIG. 7A

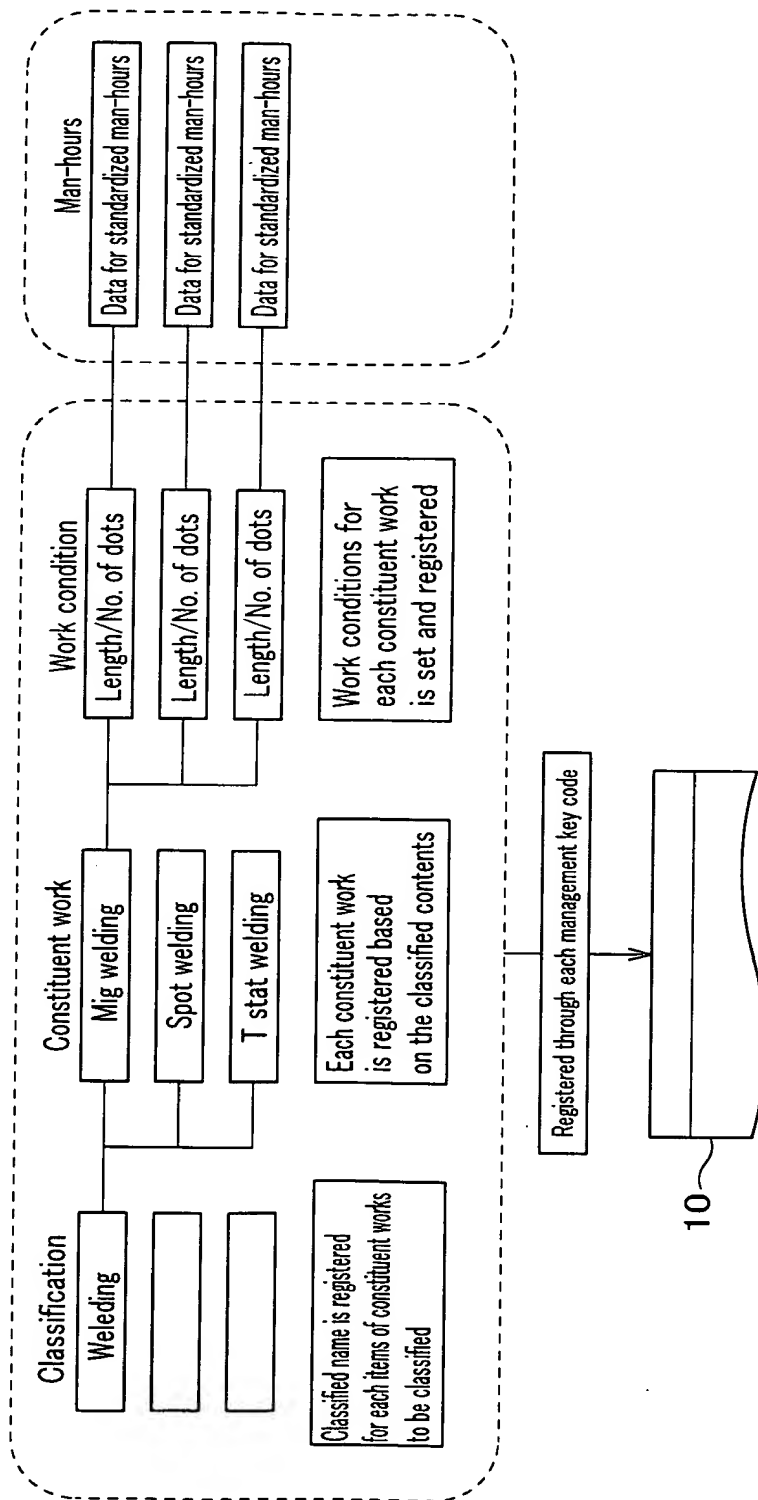


FIG. 7B

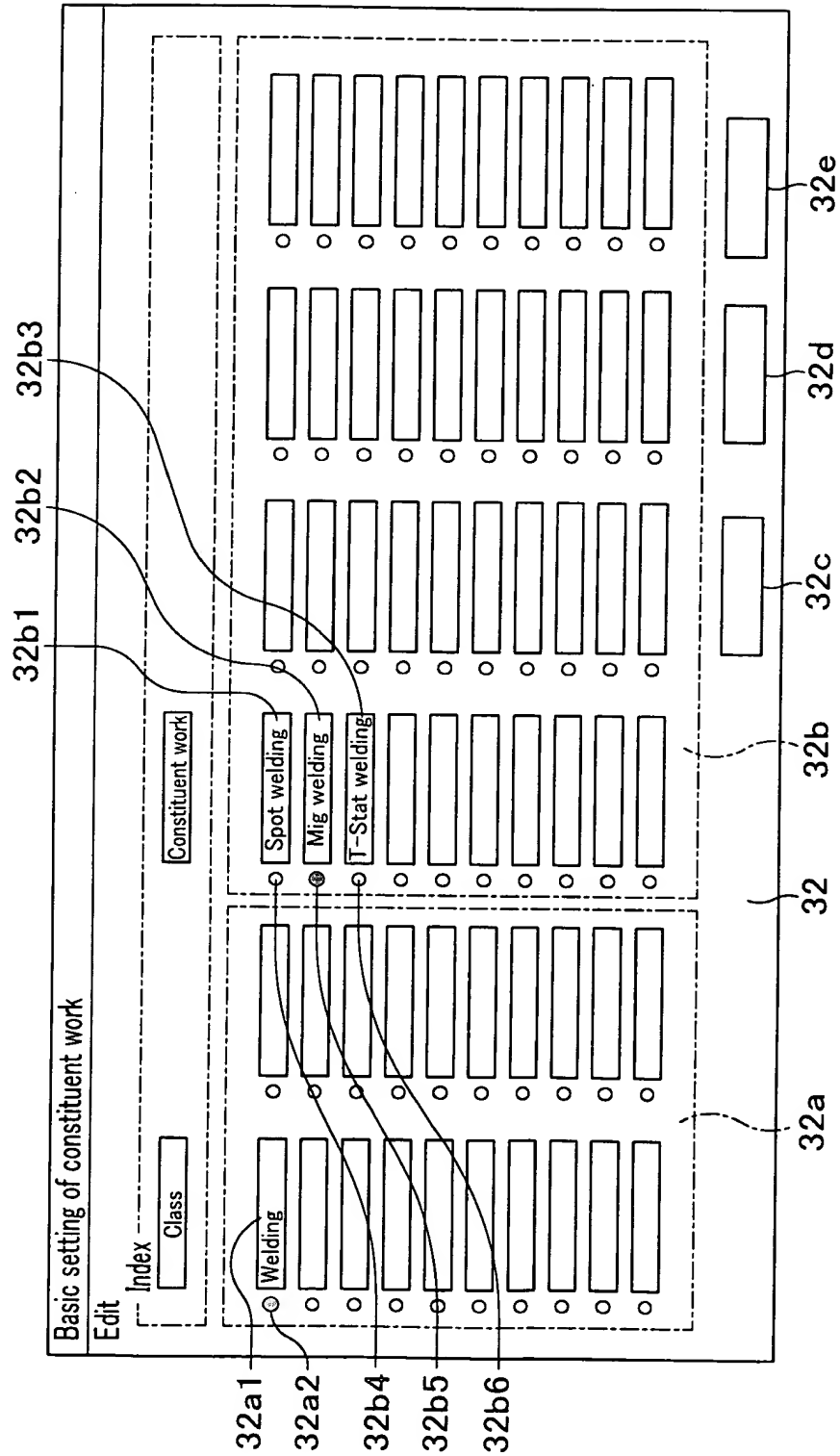


FIG. 7C

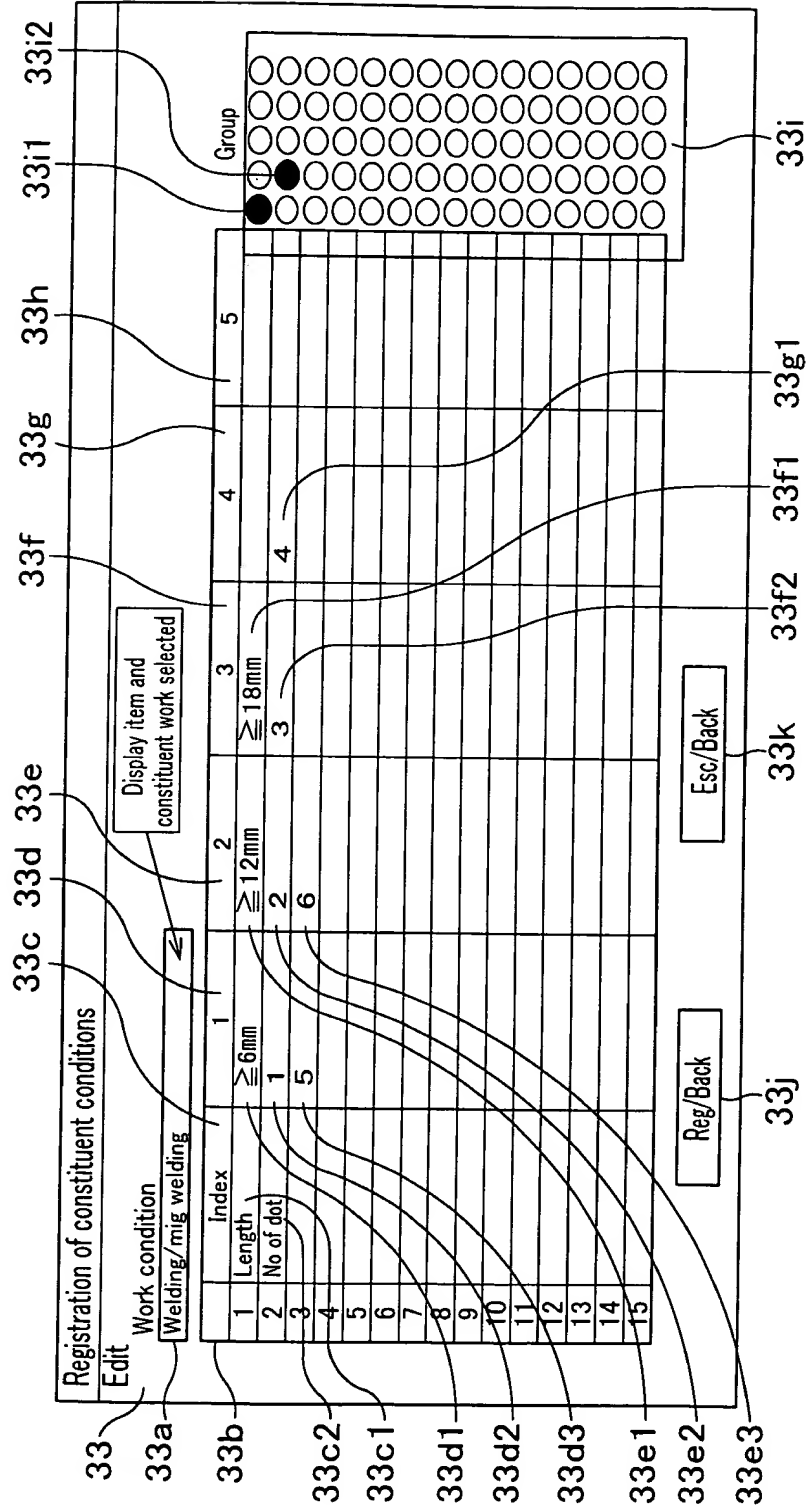


FIG. 8

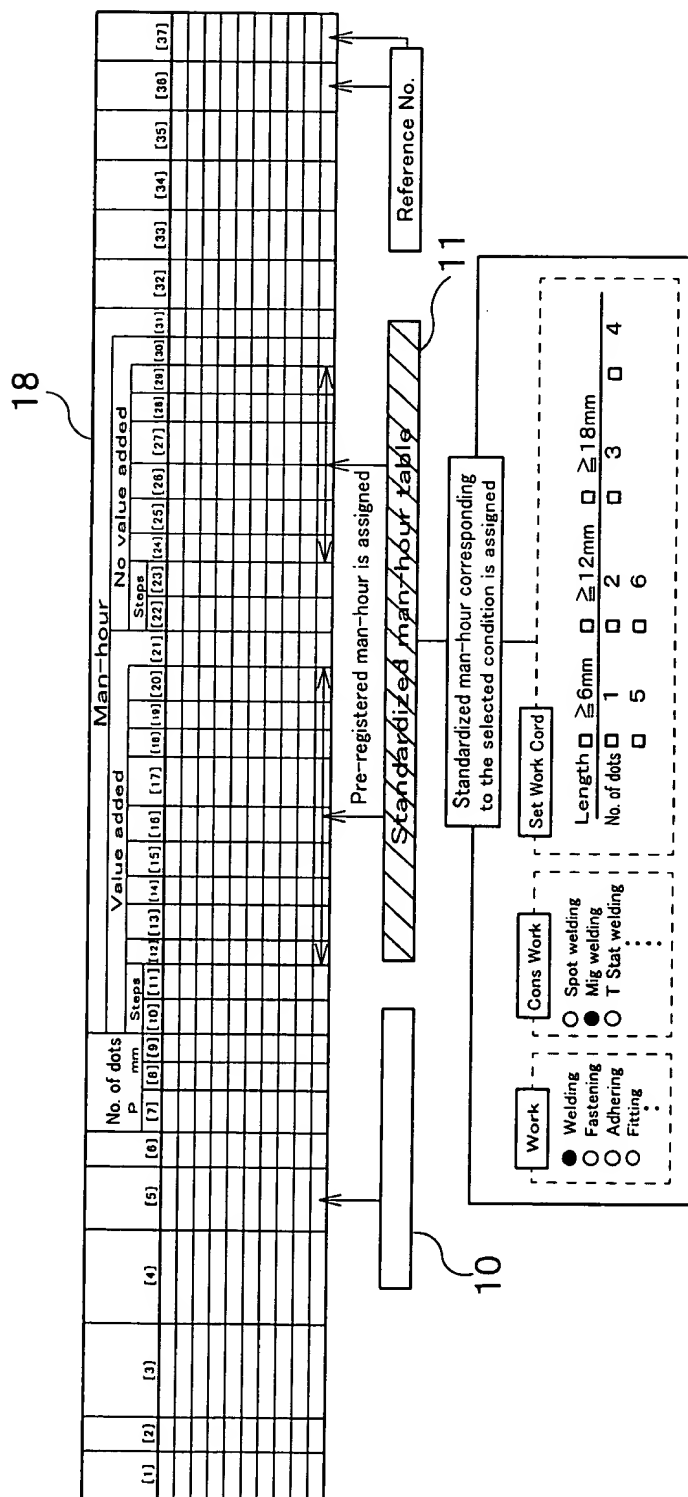
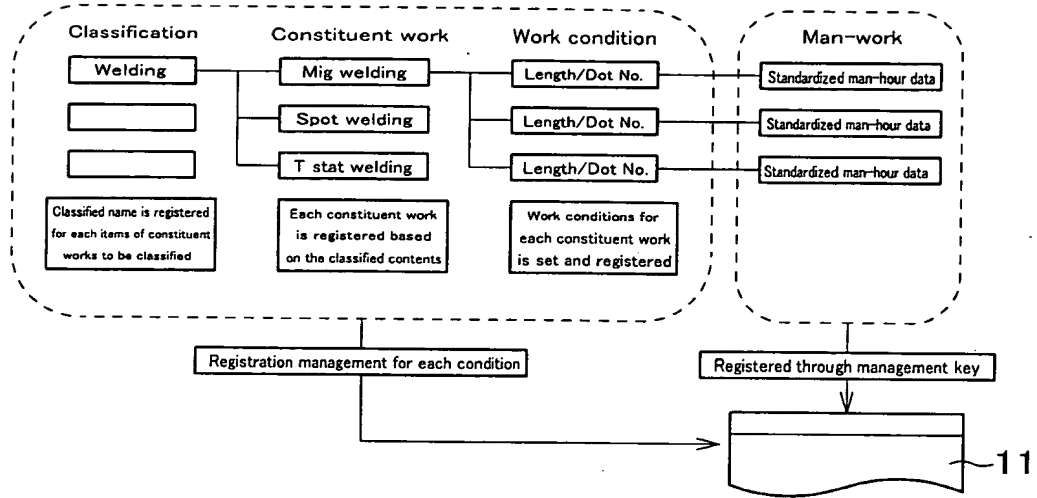


FIG.9A



05/04/2004 10:23:01

FIG.9B

34d1 34 34d 34e2 34e1 34i 34e

Select item condition of registering stand. man-work

34a Edit

Standardized Man-work Registration

34c1 Class.

Welding
 Fastening
 Adhering
 Fitting

Constituent work

Spot welding
 Mig welding
 T stat welding

Setting work cond.

Length ☒ $\geq 6\text{mm}$ ☐ $\geq 12\text{mm}$ ☐ $\geq 18\text{mm}$

Dot No. ☒ 1 ☐ 2 ☐ 3 ☐ 4
☐ 5 ☐ 6

34c

Display tot. m-work

Display end line of group

34f

Standardized man-work

Remarks

34g

34h

34b

Input standardized man-work data

34b1 34b3 34b5 34b7 34b9 34b11 34b13 34b15 34b17

34b2 34b4 34b6 34b8 34b10 34b12 34b14 34b16

34b18

[12]	[13]	[14]	[15]	[16]	[17]	[18]	[19]	[20]	[24]	[25]	[26]	[27]	[28]	[29]	[36]	[37]
------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------	------

FIG. 10A

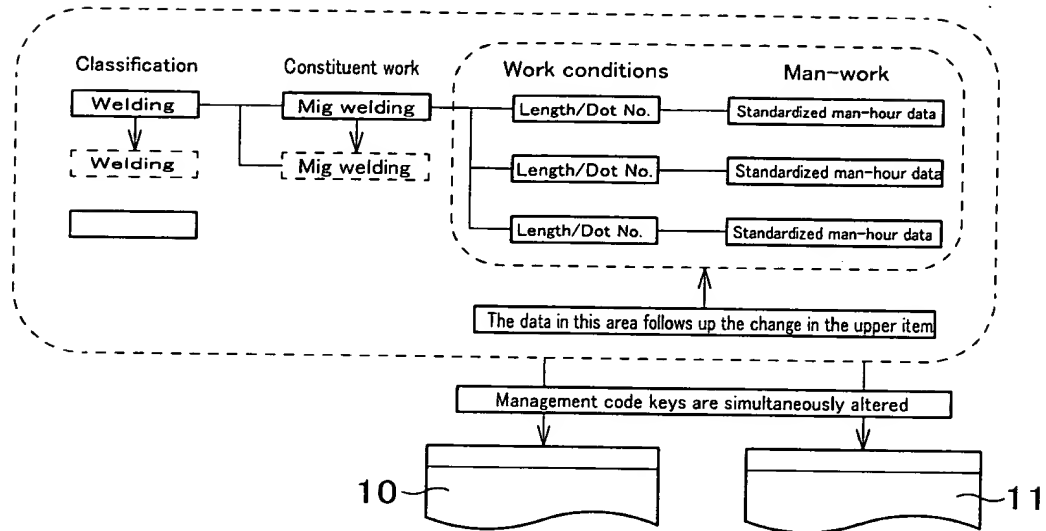


FIG. 10B

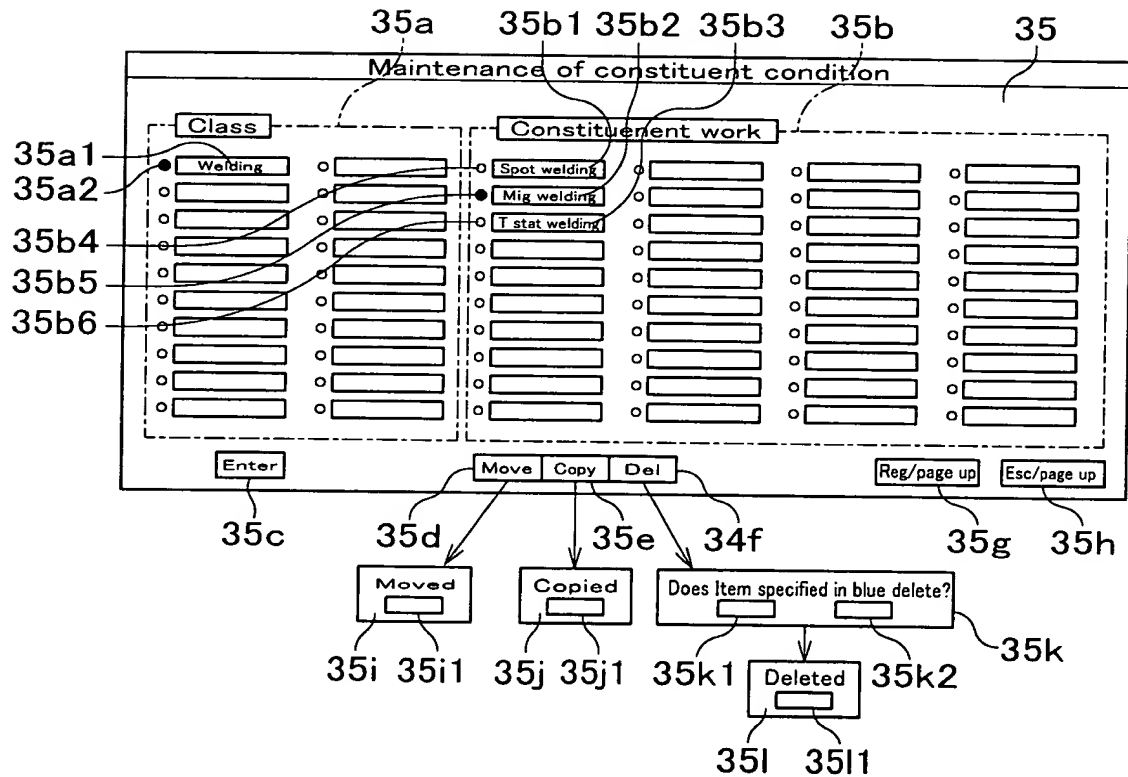


FIG. 11

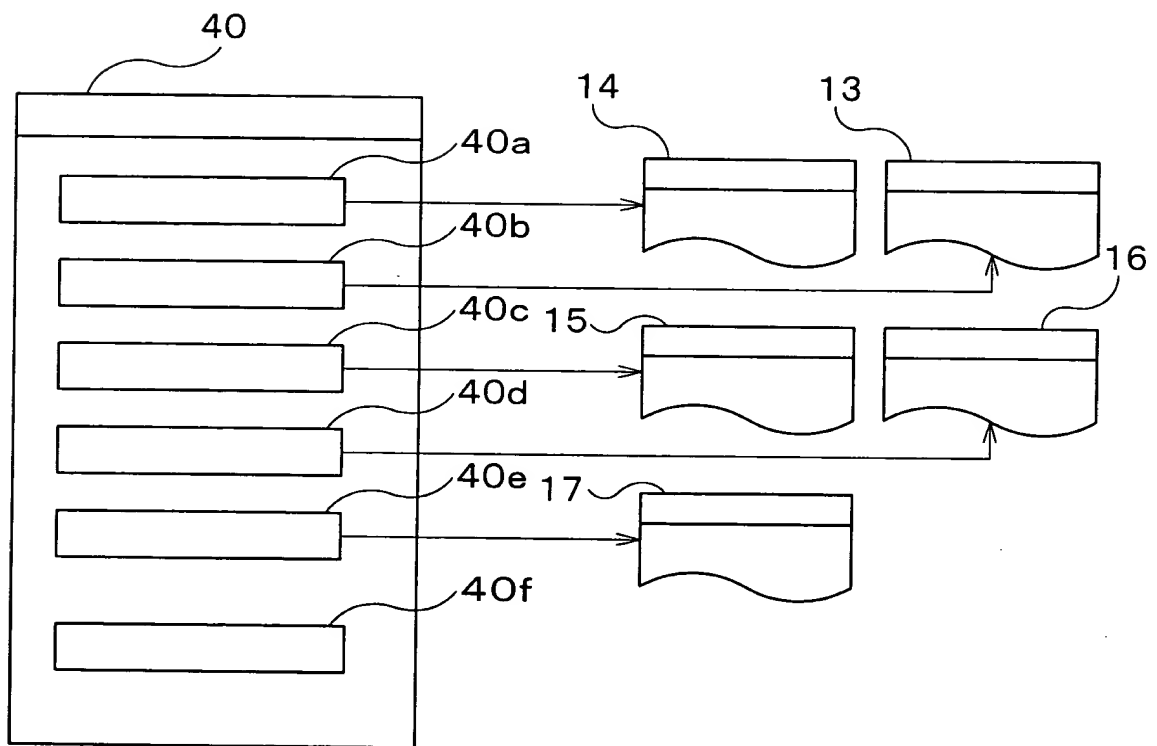


FIG. 12B

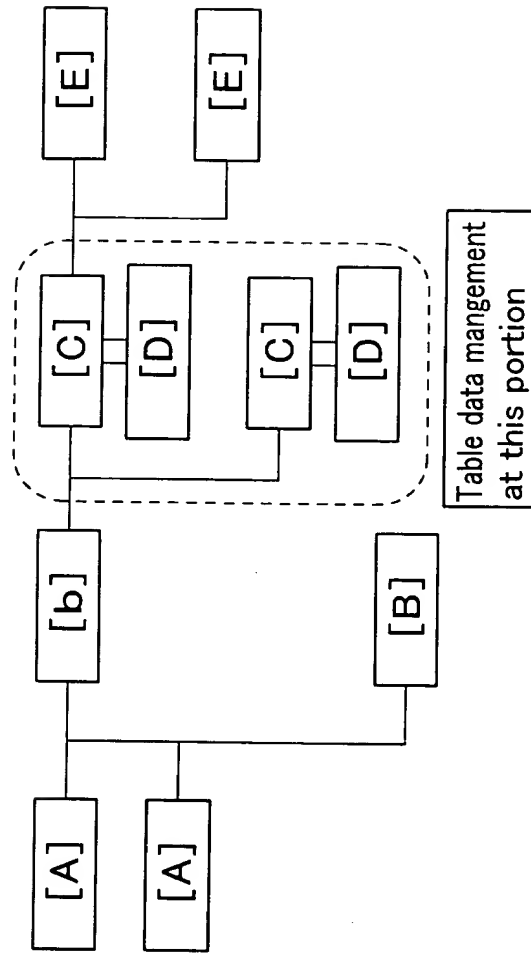
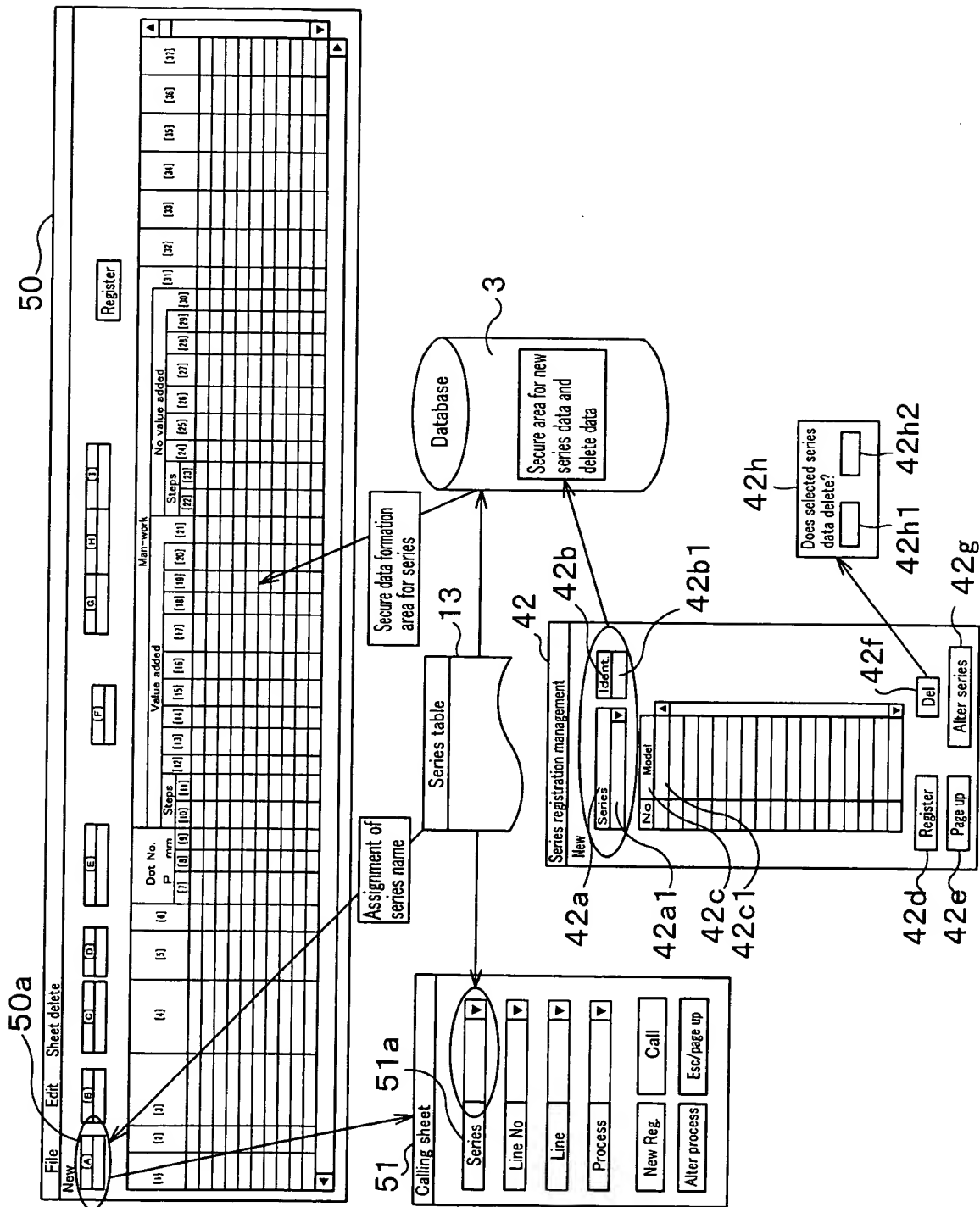


FIG. 13



THE 2010s



FIG. 15

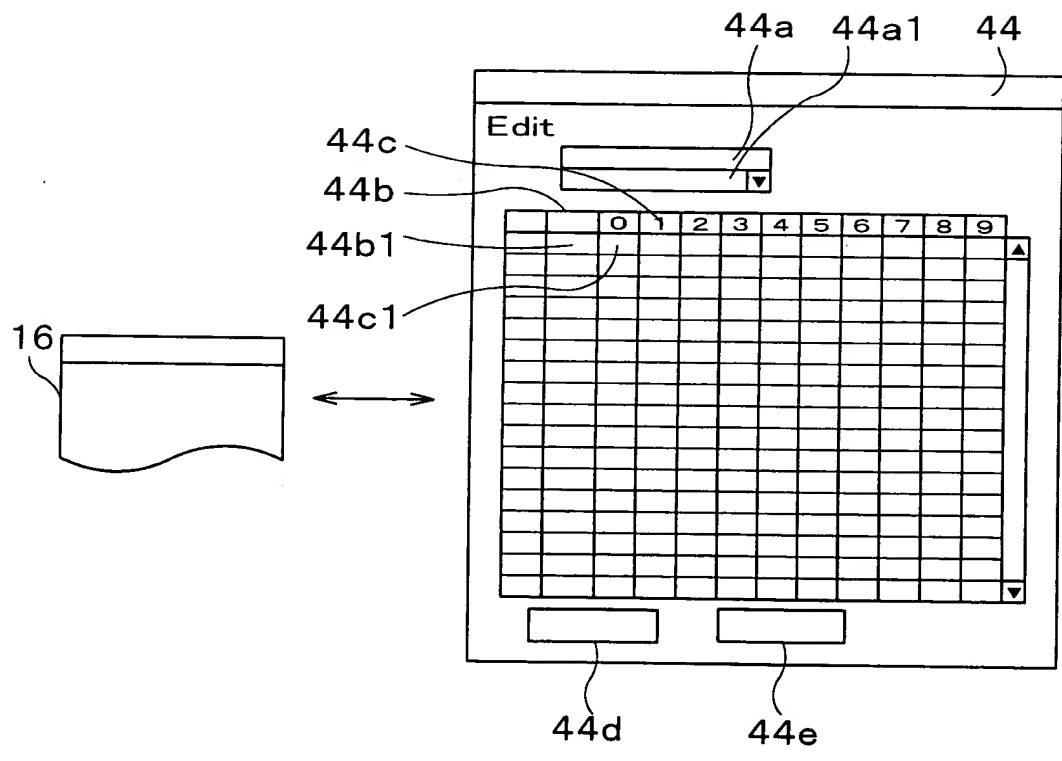


FIG. 16

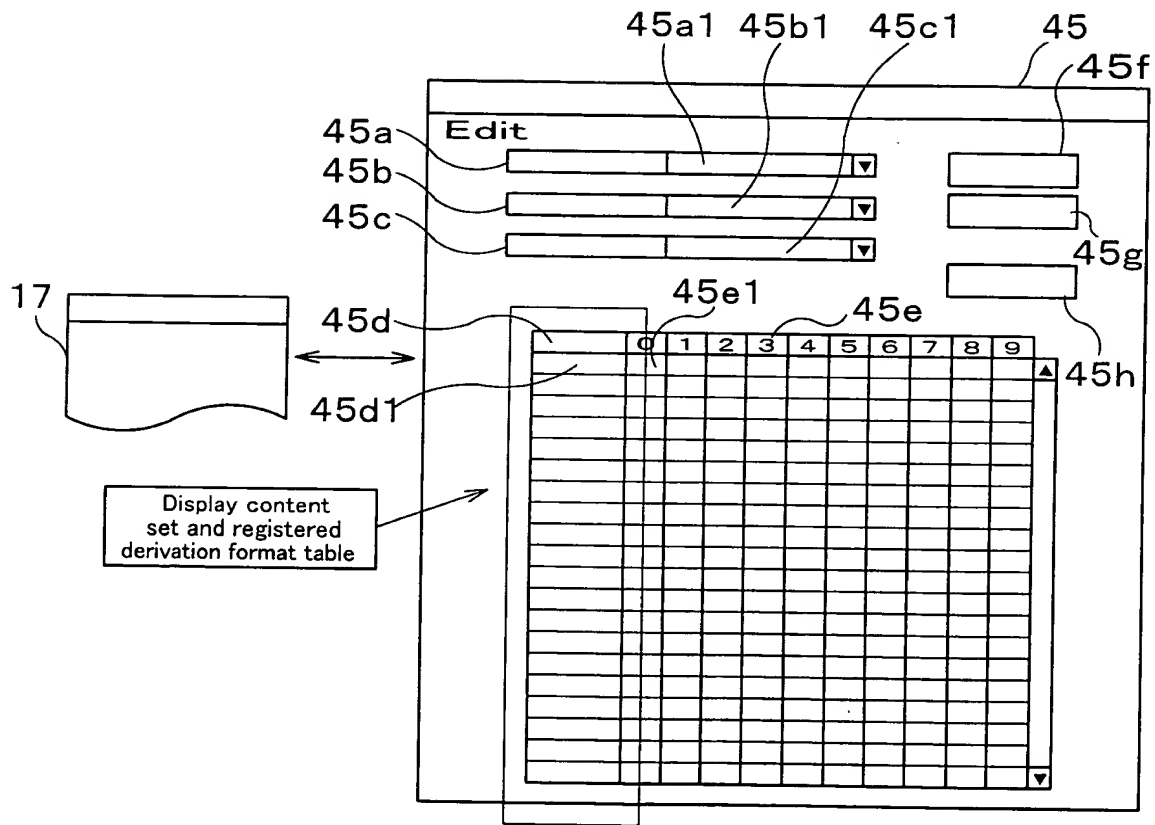


FIG. 17A

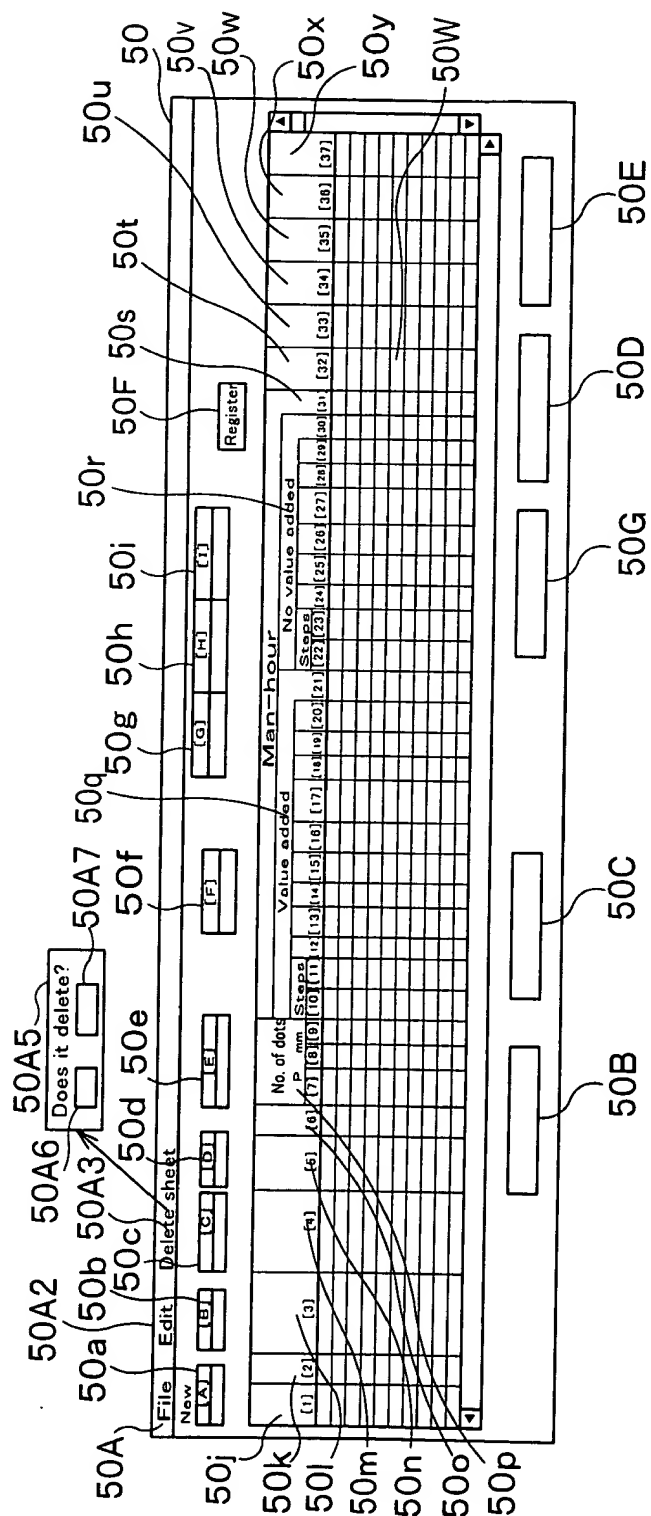


FIG. 17B

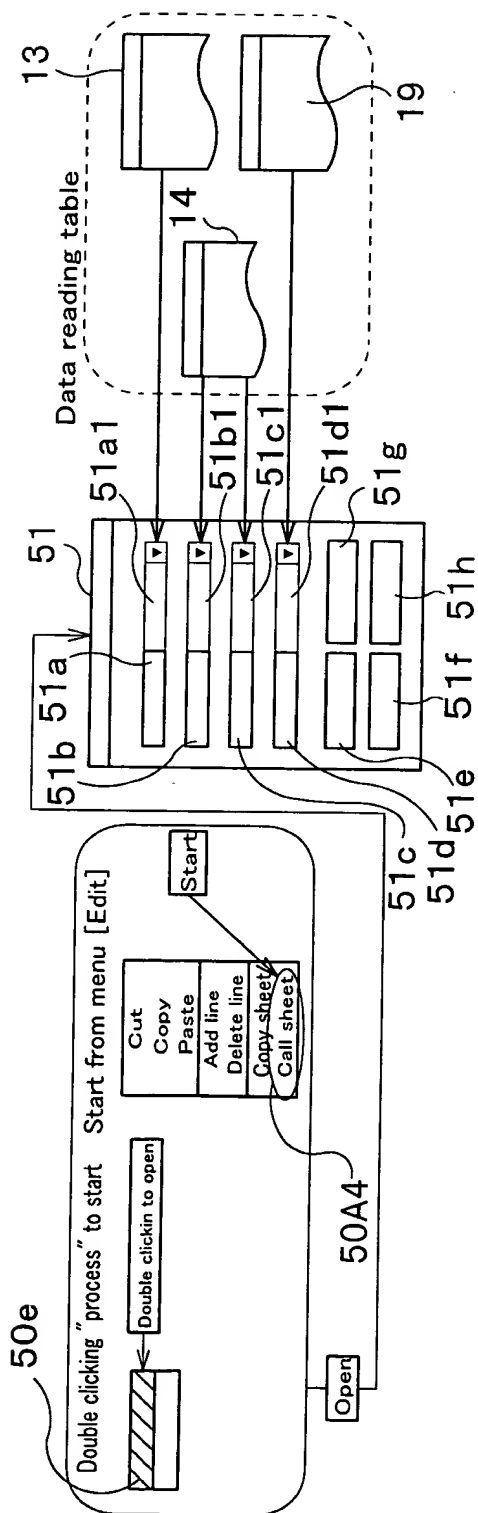


FIG. 18A

FIG. 18B

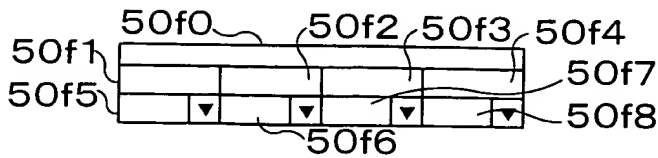


FIG. 18C

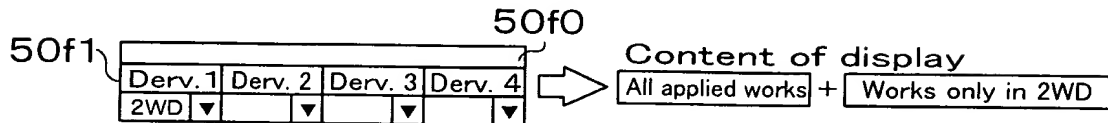


FIG. 18D

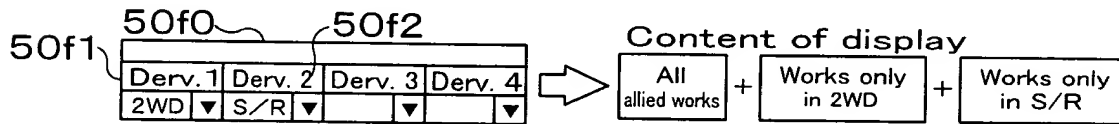


FIG. 18E

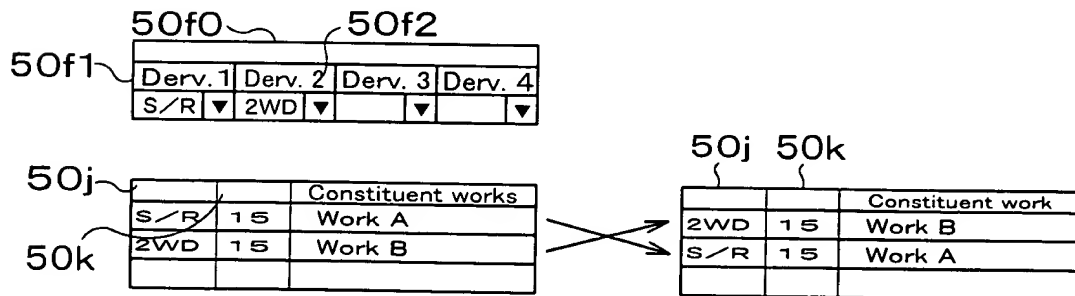


FIG. 18F

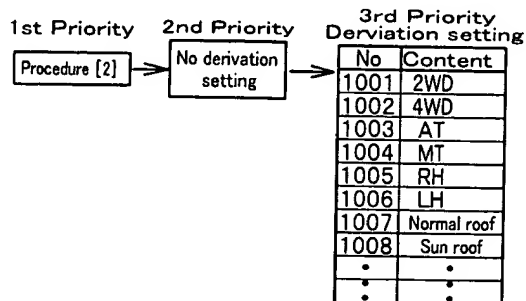


FIG. 19

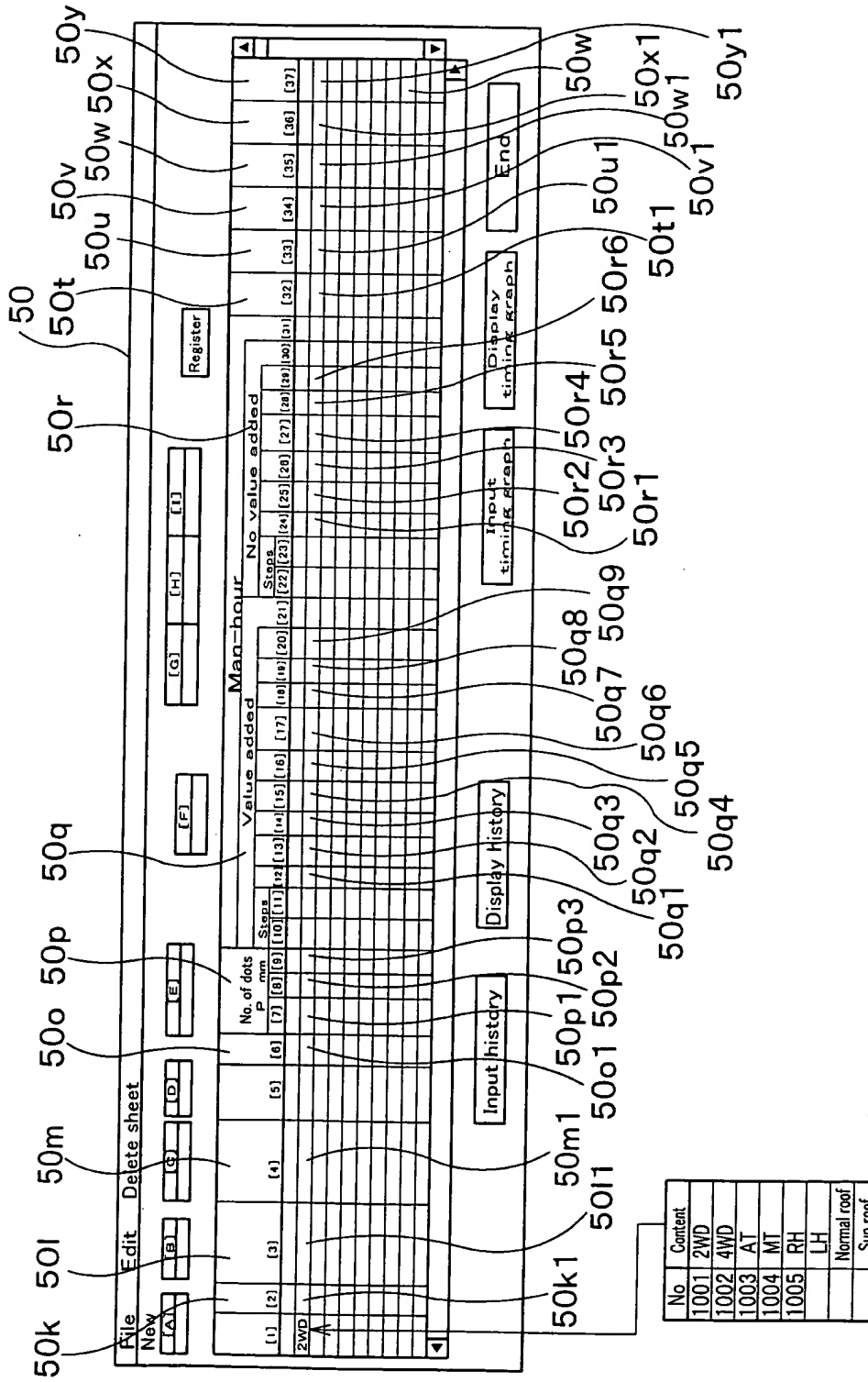
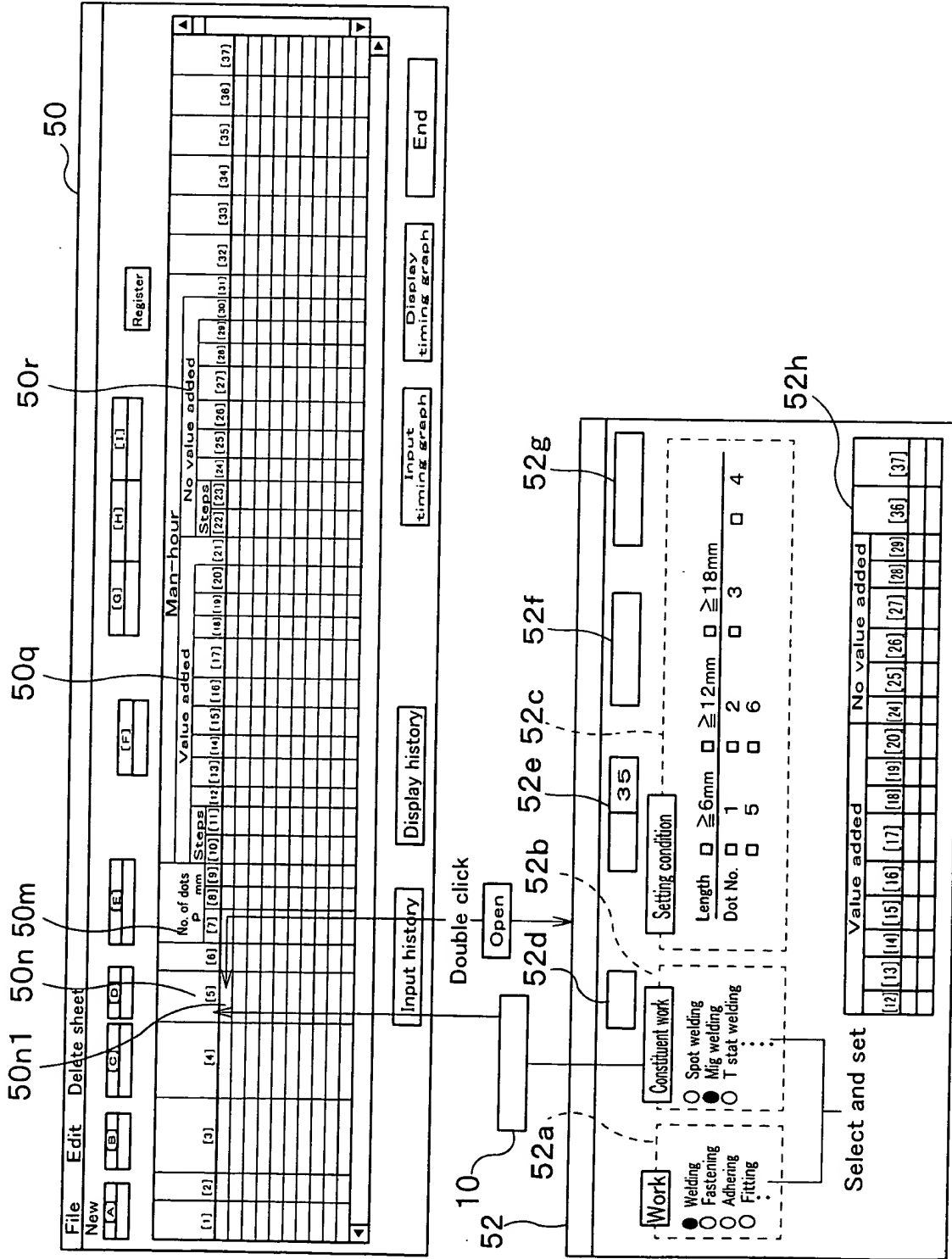


FIG. 20



50r (50)

[illegible]

Write the total of wait [1] ~ [5] on wait [29] of
main man-work management as a line unit
*write at storage of timing data in man works

Processing main data
Subtotal [30] + [31] is re-calculated
and is required to be written on DB

2025年12月13日

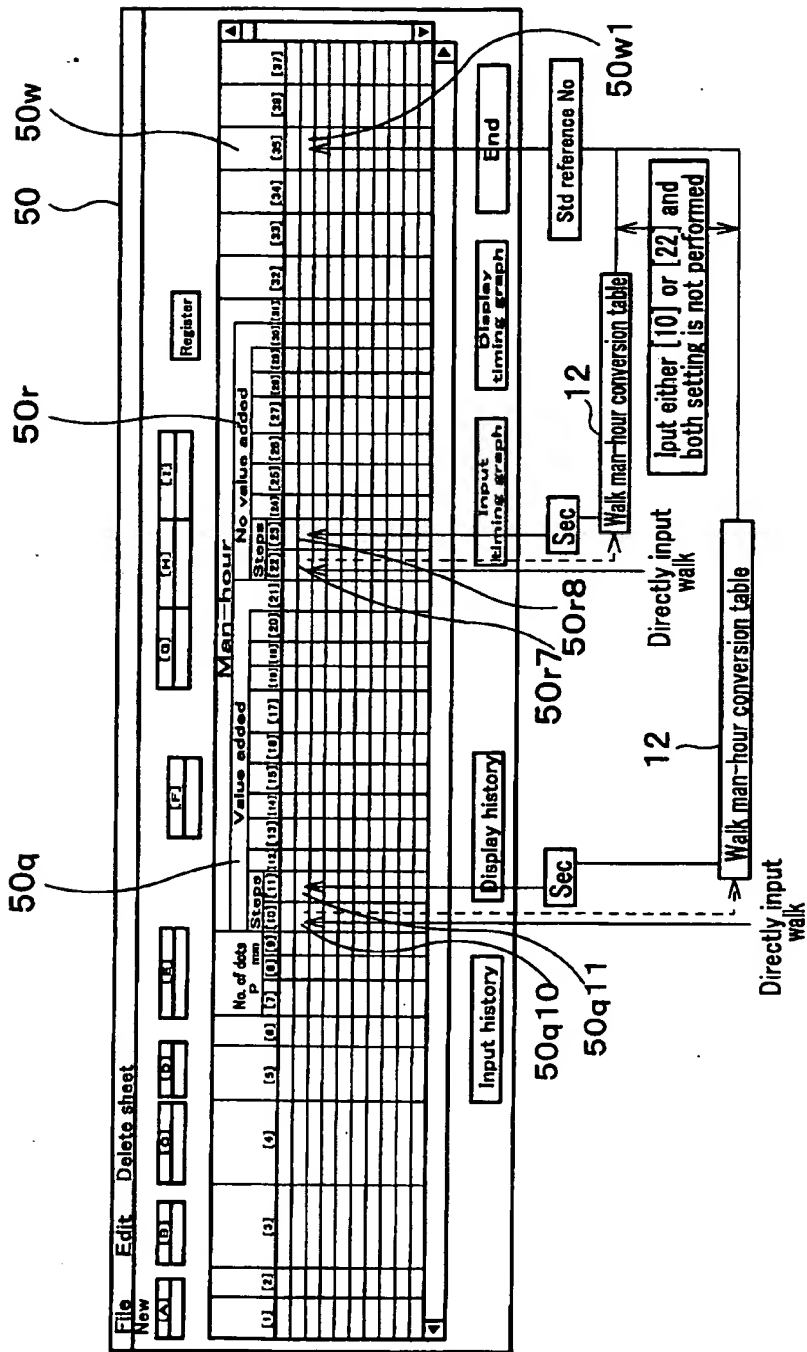


FIG. 23

FIG. 23

50q

50h

50h1

50

50q12

50w

File New Edit Delete sheet

(A) (B) (C) (D) (E) (F)

Proc. per sheet

Register

Total of [H] + [I] in sheet unit

Sub-total of each line [2]

Man-hour

Steps	Value added				No value added			
	[10]	[11]	[12]	[13]	[14]	[15]	[16]	[17]
[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]	[9]
[10]	[11]	[12]	[13]	[14]	[15]	[16]	[17]	[18]
[20]	[21]	[22]	[23]	[24]	[25]	[26]	[27]	[28]
[30]	[31]	[32]	[33]	[34]	[35]	[36]	[37]	[38]

Input history

Display history

Input timing graph

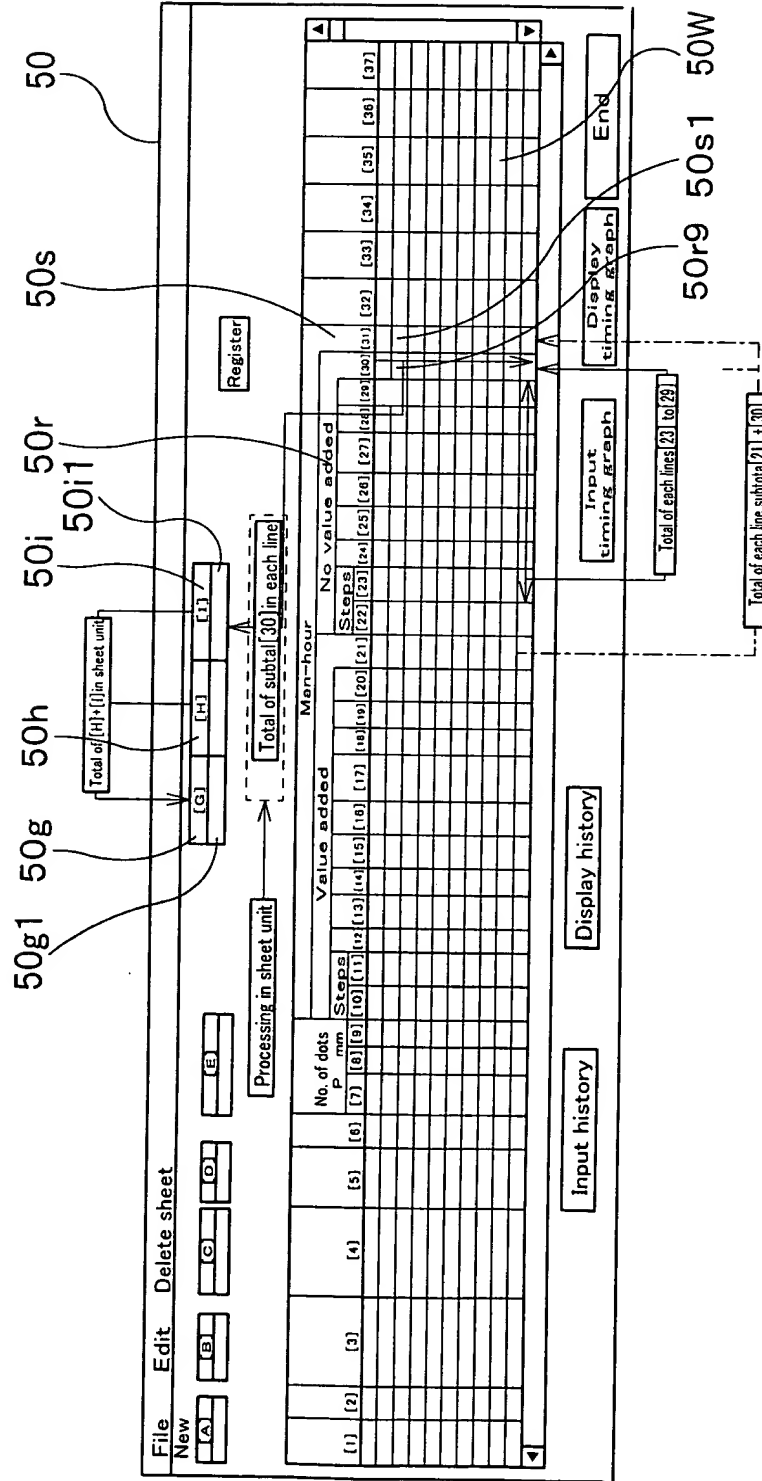
Display timing graph

End

Total of [11] - [20] per line

Total of each line subtotals [21] + [30]

FIG. 24



[illegible]

FIG. 26

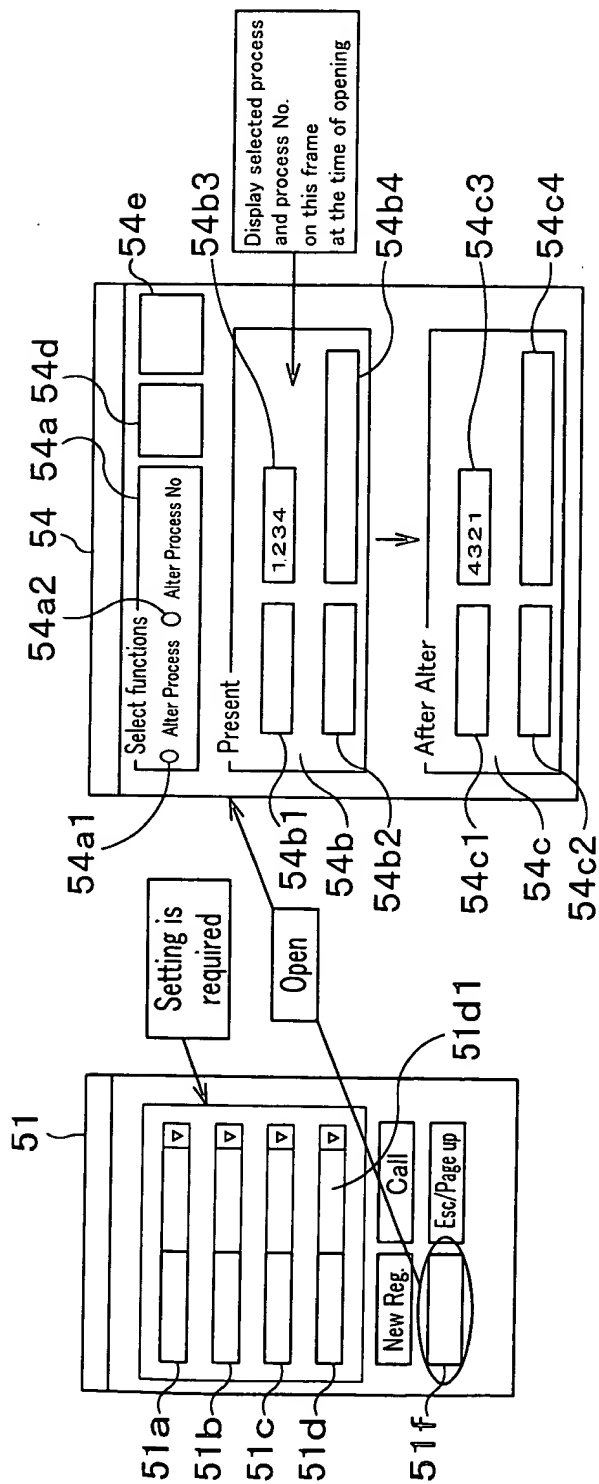
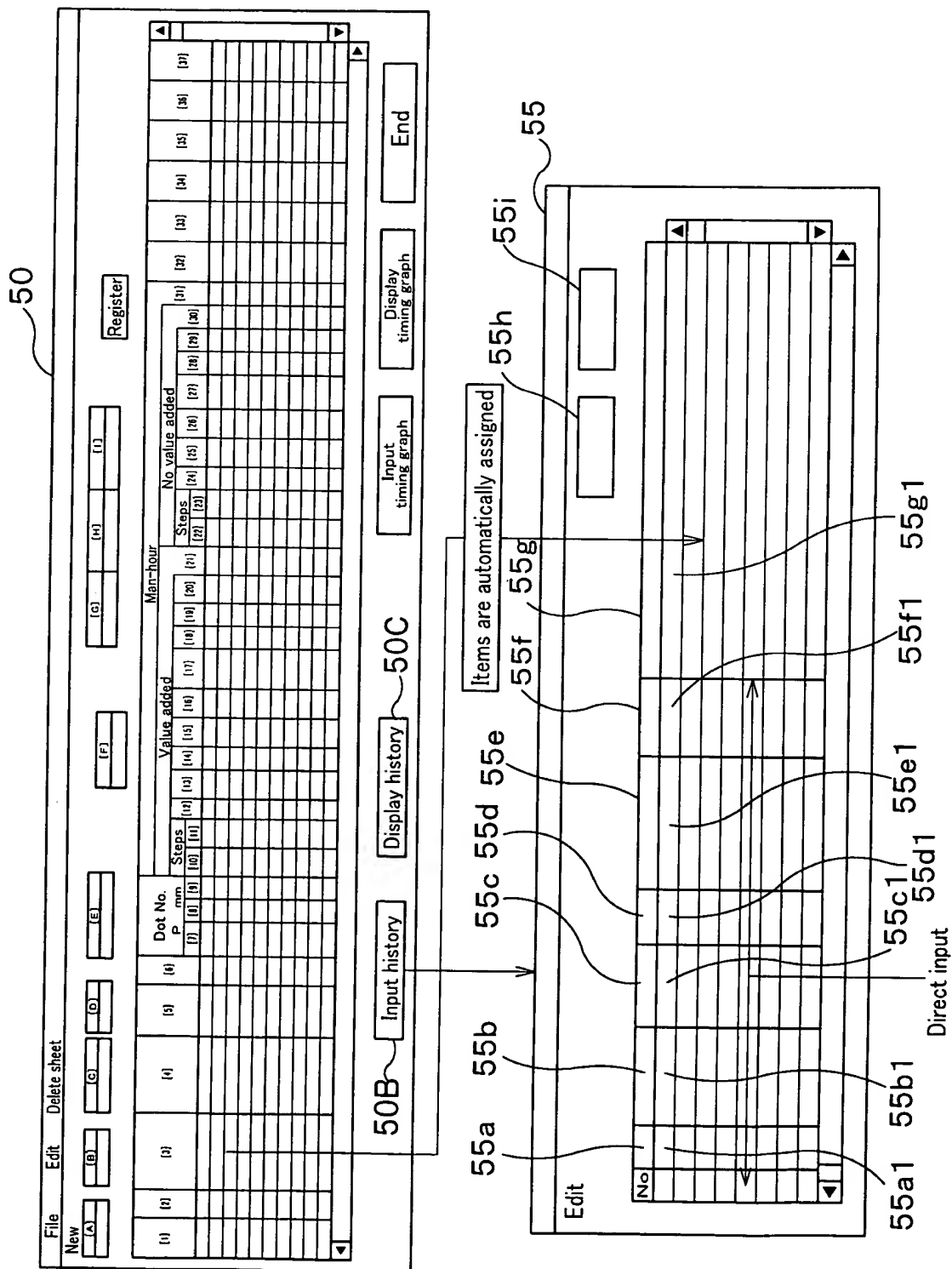


FIG. 27



(The page contains faint, illegible markings or bleed-through from the reverse side.)

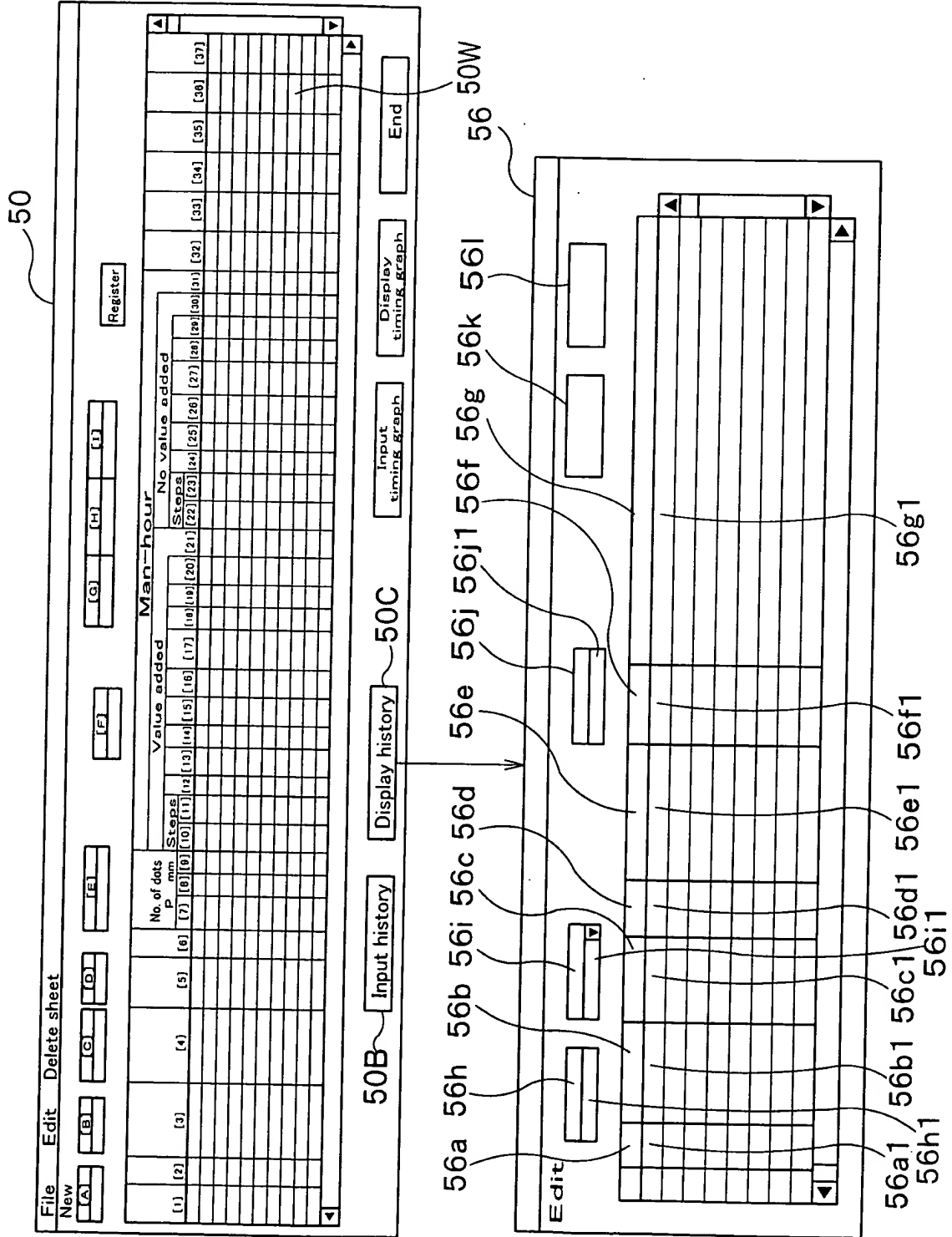


FIG.29A

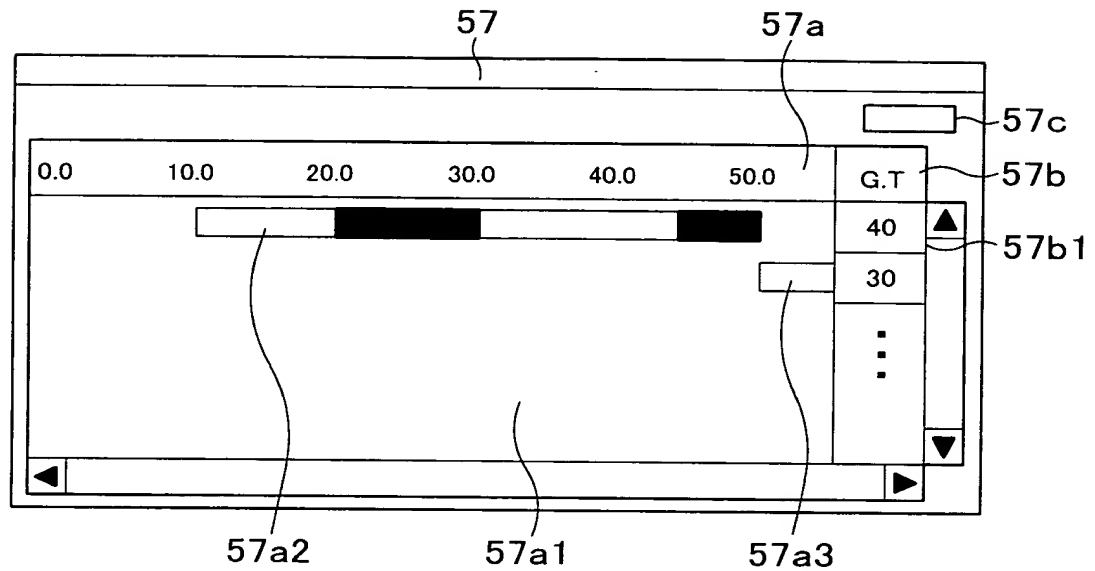
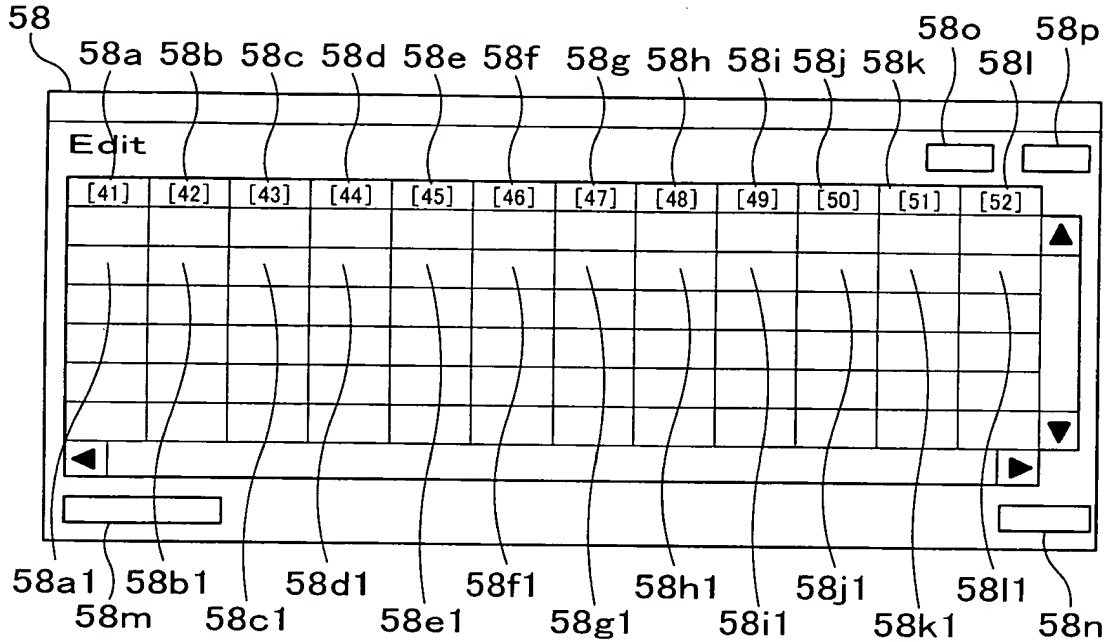


FIG. 29B



1. 1. The first part of the report
 2. 2. The second part of the report
 3. 3. The third part of the report
 4. 4. The fourth part of the report
 5. 5. The fifth part of the report
 6. 6. The sixth part of the report
 7. 7. The seventh part of the report
 8. 8. The eighth part of the report
 9. 9. The ninth part of the report
 10. 10. The tenth part of the report
 11. 11. The eleventh part of the report
 12. 12. The twelfth part of the report
 13. 13. The thirteenth part of the report
 14. 14. The fourteenth part of the report
 15. 15. The fifteenth part of the report
 16. 16. The sixteenth part of the report
 17. 17. The seventeenth part of the report
 18. 18. The eighteenth part of the report
 19. 19. The nineteenth part of the report
 20. 20. The twentieth part of the report
 21. 21. The twenty-first part of the report
 22. 22. The twenty-second part of the report
 23. 23. The twenty-third part of the report
 24. 24. The twenty-fourth part of the report
 25. 25. The twenty-fifth part of the report
 26. 26. The twenty-sixth part of the report
 27. 27. The twenty-seventh part of the report
 28. 28. The twenty-eighth part of the report
 29. 29. The twenty-ninth part of the report
 30. 30. The thirtieth part of the report
 31. 31. The thirty-first part of the report
 32. 32. The thirty-second part of the report
 33. 33. The thirty-third part of the report
 34. 34. The thirty-fourth part of the report
 35. 35. The thirty-fifth part of the report
 36. 36. The thirty-sixth part of the report
 37. 37. The thirty-seventh part of the report
 38. 38. The thirty-eighth part of the report
 39. 39. The thirty-ninth part of the report
 40. 40. The fortieth part of the report
 41. 41. The forty-first part of the report
 42. 42. The forty-second part of the report
 43. 43. The forty-third part of the report
 44. 44. The forty-fourth part of the report
 45. 45. The forty-fifth part of the report
 46. 46. The forty-sixth part of the report
 47. 47. The forty-seventh part of the report
 48. 48. The forty-eighth part of the report
 49. 49. The forty-ninth part of the report
 50. 50. The fiftieth part of the report
 51. 51. The fifty-first part of the report
 52. 52. The fifty-second part of the report
 53. 53. The fifty-third part of the report
 54. 54. The fifty-fourth part of the report
 55. 55. The fifty-fifth part of the report
 56. 56. The fifty-sixth part of the report
 57. 57. The fifty-seventh part of the report
 58. 58. The fifty-eighth part of the report
 59. 59. The fifty-ninth part of the report
 60. 60. The sixtieth part of the report
 61. 61. The sixty-first part of the report
 62. 62. The sixty-second part of the report
 63. 63. The sixty-third part of the report
 64. 64. The sixty-fourth part of the report
 65. 65. The sixty-fifth part of the report
 66. 66. The sixty-sixth part of the report
 67. 67. The sixty-seventh part of the report
 68. 68. The sixty-eighth part of the report
 69. 69. The sixty-ninth part of the report
 70. 70. The seventieth part of the report
 71. 71. The seventy-first part of the report
 72. 72. The seventy-second part of the report
 73. 73. The seventy-third part of the report
 74. 74. The seventy-fourth part of the report
 75. 75. The seventy-fifth part of the report
 76. 76. The seventy-sixth part of the report
 77. 77. The seventy-seventh part of the report
 78. 78. The seventy-eighth part of the report
 79. 79. The seventy-ninth part of the report
 80. 80. The eightieth part of the report
 81. 81. The eighty-first part of the report
 82. 82. The eighty-second part of the report
 83. 83. The eighty-third part of the report
 84. 84. The eighty-fourth part of the report
 85. 85. The eighty-fifth part of the report
 86. 86. The eighty-sixth part of the report
 87. 87. The eighty-seventh part of the report
 88. 88. The eighty-eighth part of the report
 89. 89. The eighty-ninth part of the report
 90. 90. The ninetieth part of the report
 91. 91. The ninety-first part of the report
 92. 92. The ninety-second part of the report
 93. 93. The ninety-third part of the report
 94. 94. The ninety-fourth part of the report
 95. 95. The ninety-fifth part of the report
 96. 96. The ninety-sixth part of the report
 97. 97. The ninety-seventh part of the report
 98. 98. The ninety-eighth part of the report
 99. 99. The ninety-ninth part of the report
 100. 100. The hundredth part of the report

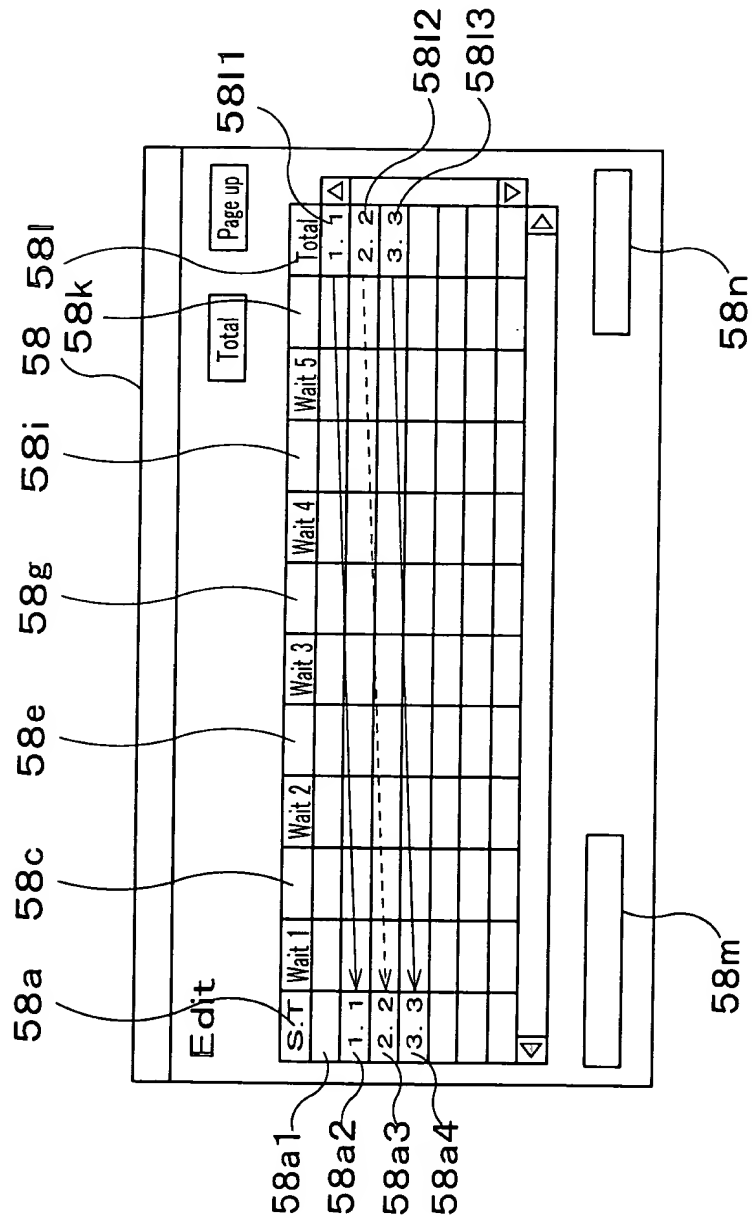
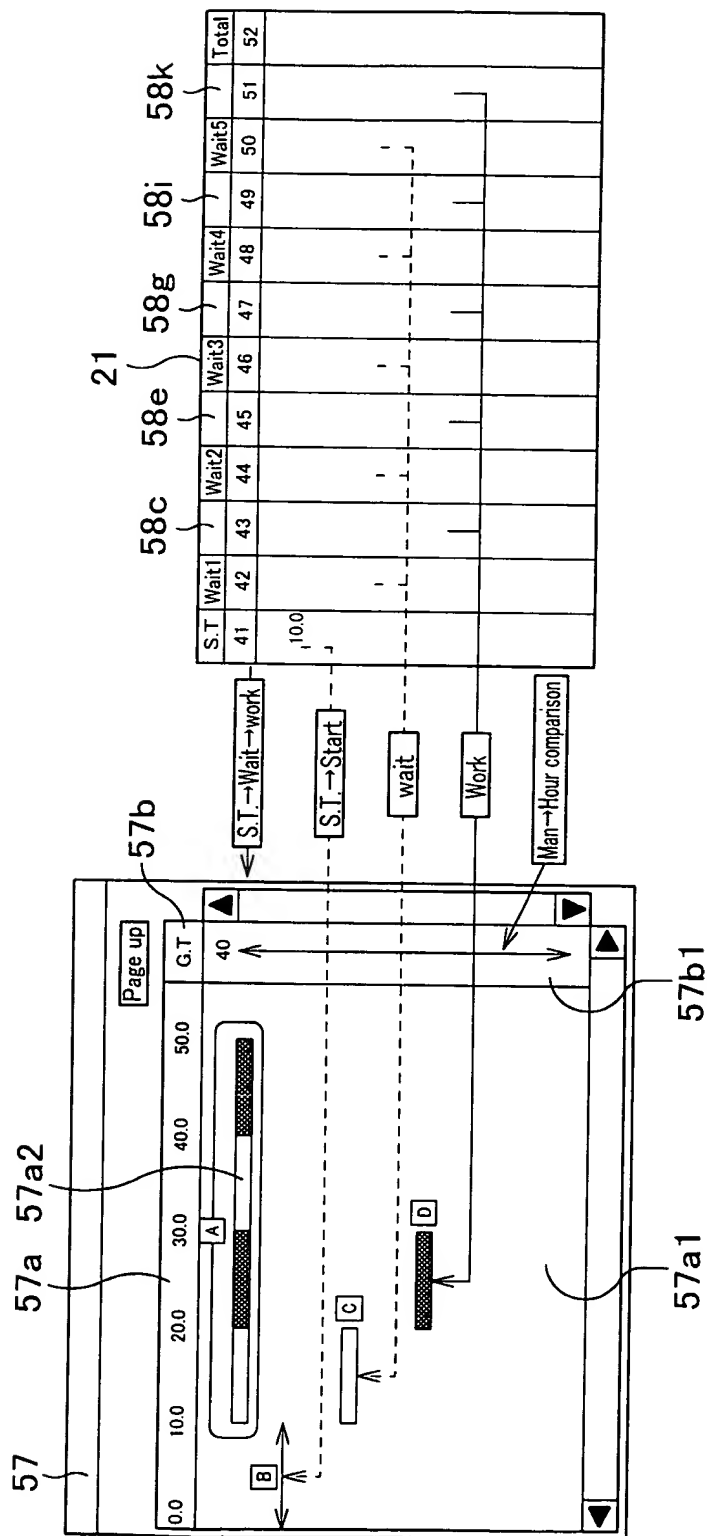


FIG. 32



FD 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16

FIG.33A

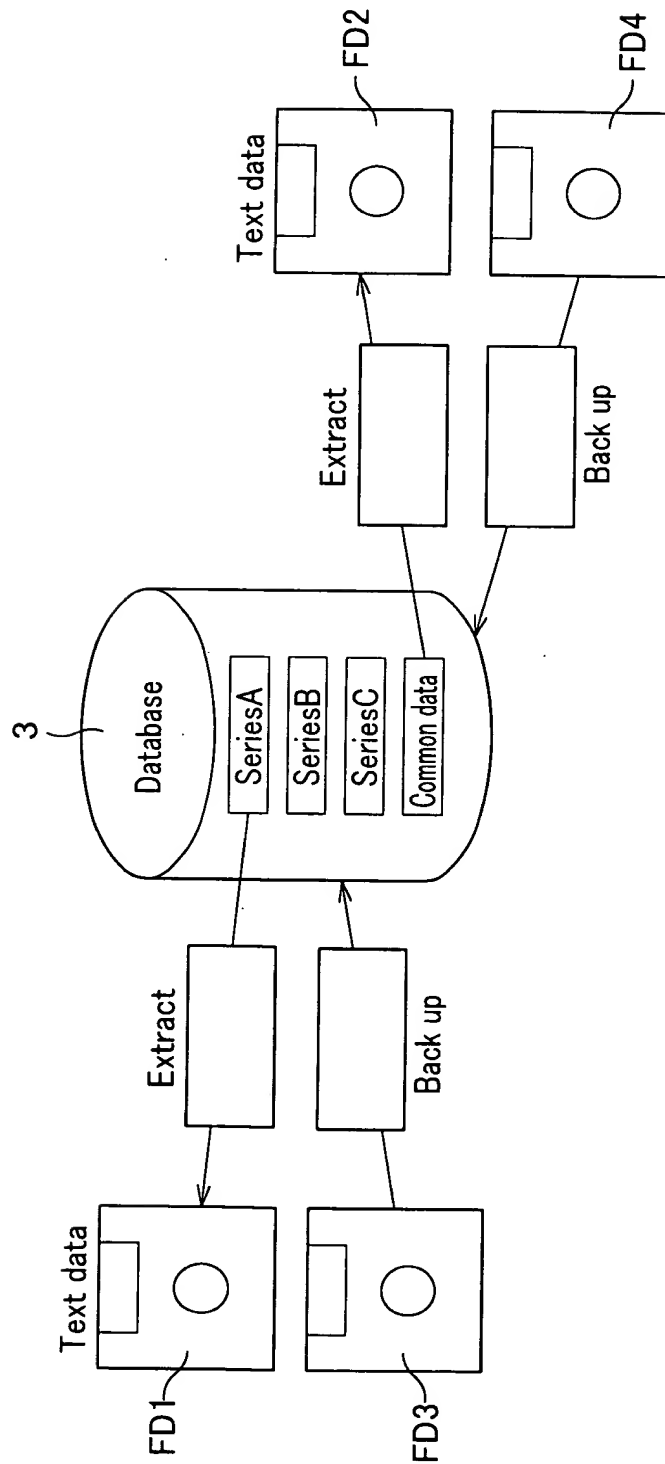


FIG. 33B

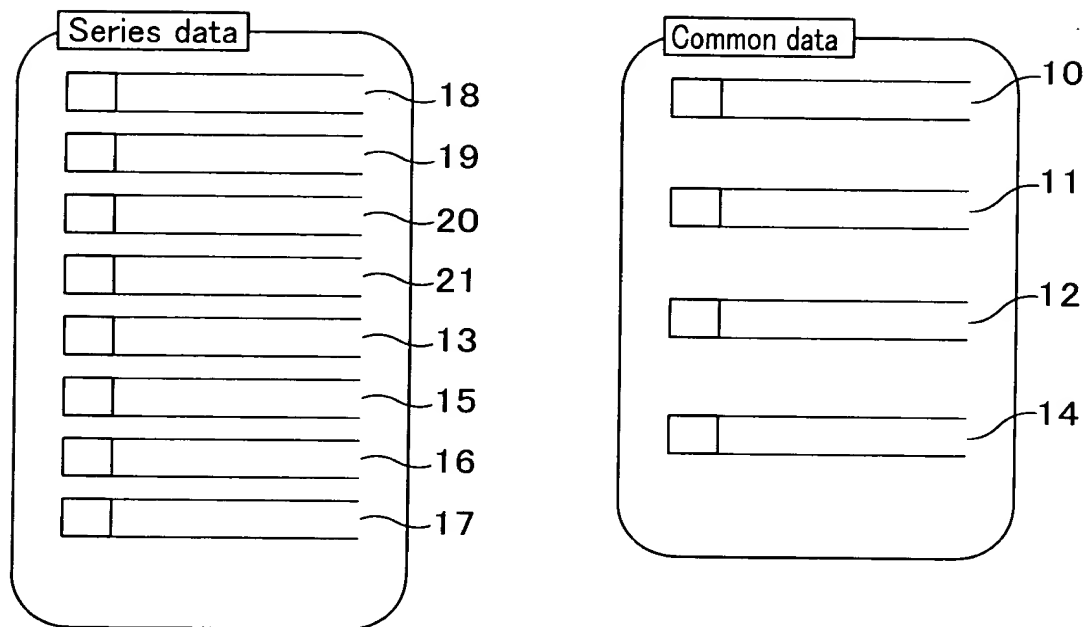


FIG. 34

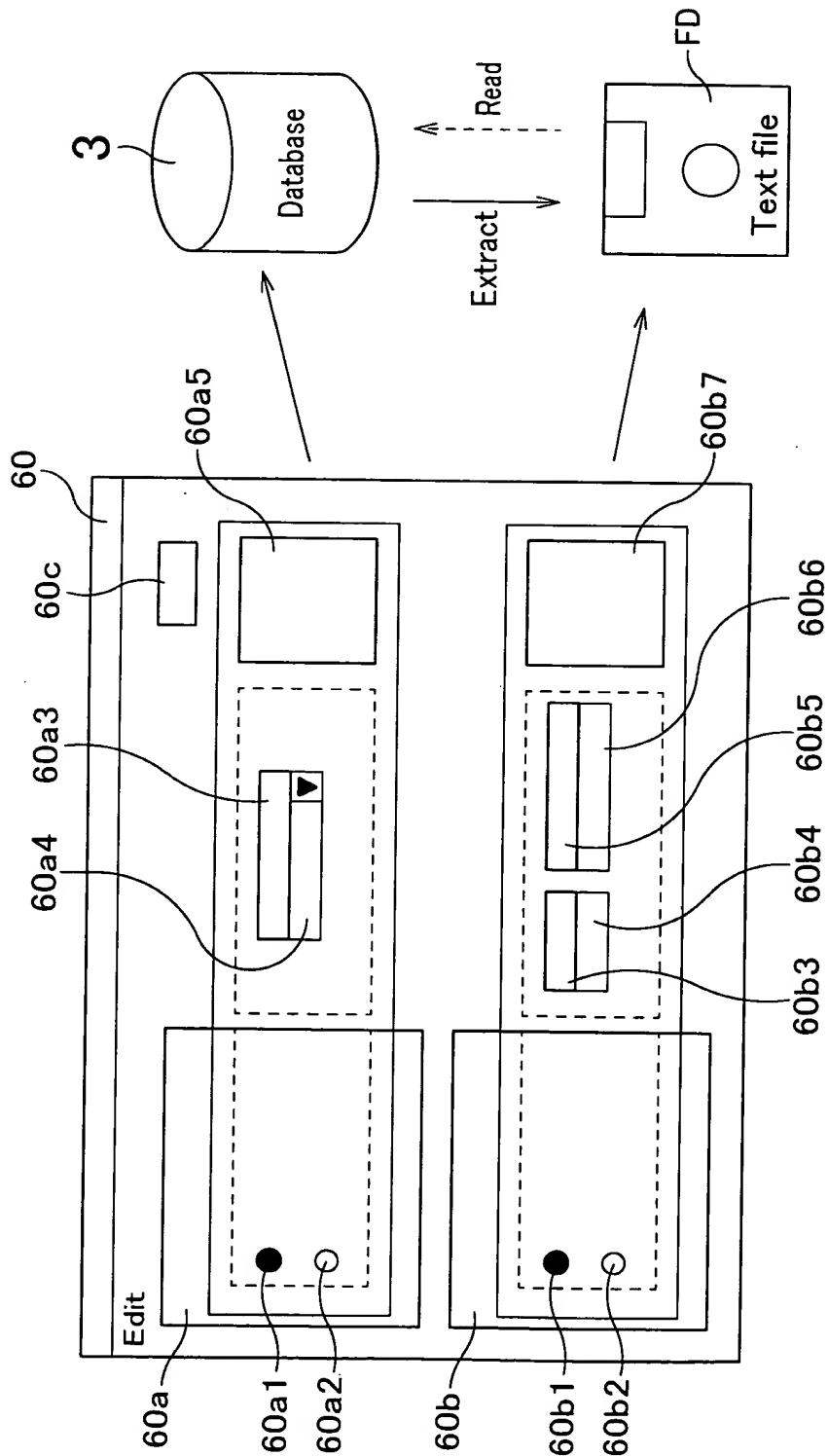
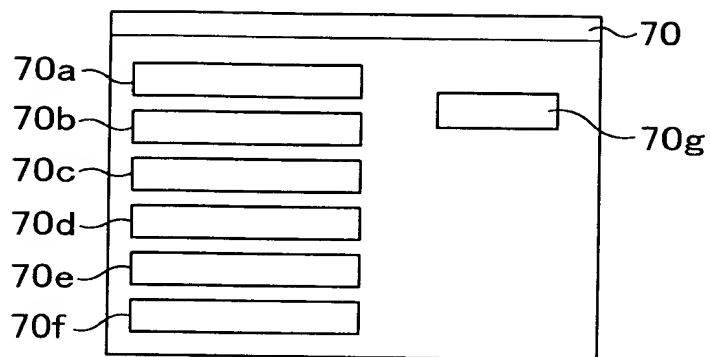


FIG. 35



09642472.042601

FIG. 37A

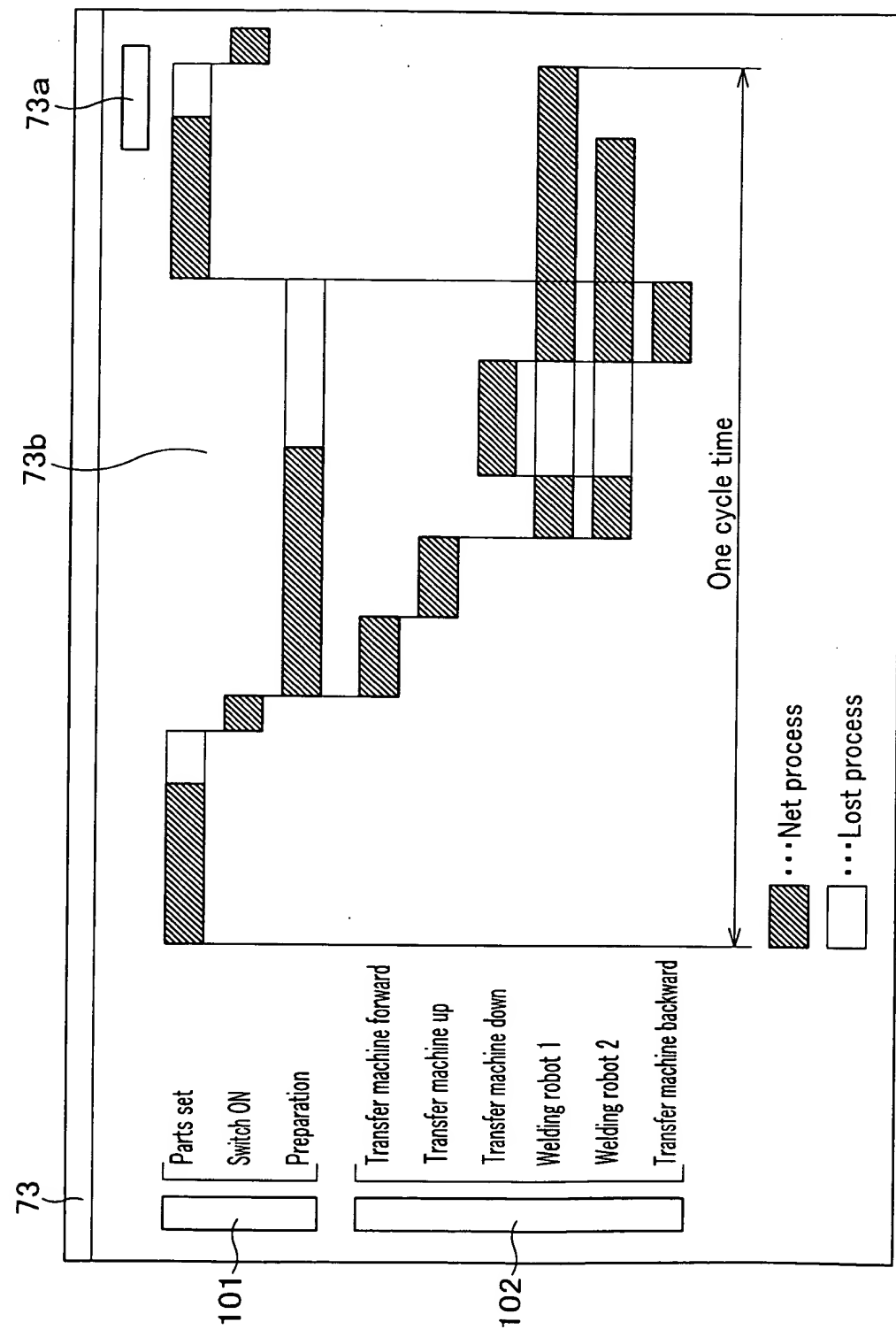
72
72a
72a1
72b1
72b
72d

Serie	No condition	No condition	No condition	No condition	No condition
Line NO.	No condition	No condition	No condition	No condition	No condition
Line name	SP OUT	SP COMP	FR W/H		
Cost sensor	211105	211105	211101		
Process	No condition				
Derivation	No condition				

1	FR W/H	211101	SET LH	1	Side frame	Off
2				2	Side frame	Out
3				3	Side frame	Turn
4				4	Side frame	Set
5				5	Clamper	Push button
6				6	Dumper housing	Off
7				7	Dumper housing	Out

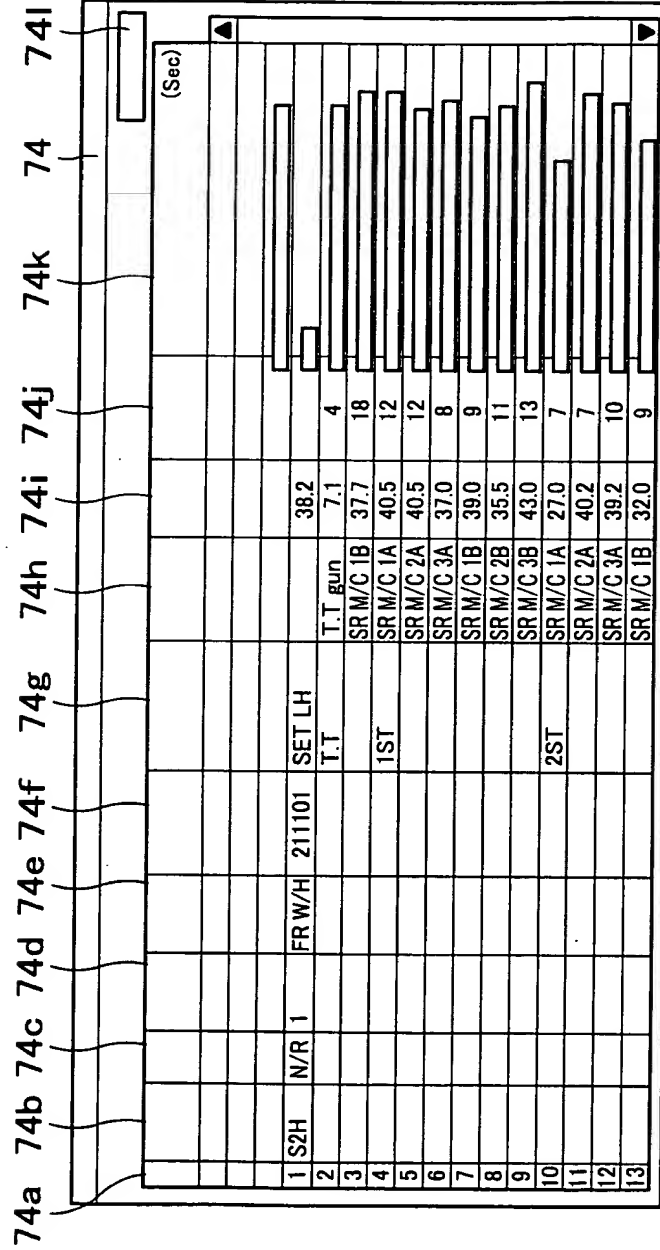
72c

FIG. 37B



74a 74b 74c 74d 74e 74f 74g 74h 74i 74j 74k 74 74l

FIG.38



75a 75b 75c 75d 75e 75f 75g 75h 75i 75j 75k 75l 75m 75n 75o 75p

75r1 75r1

FIG. 40

FIG. 40

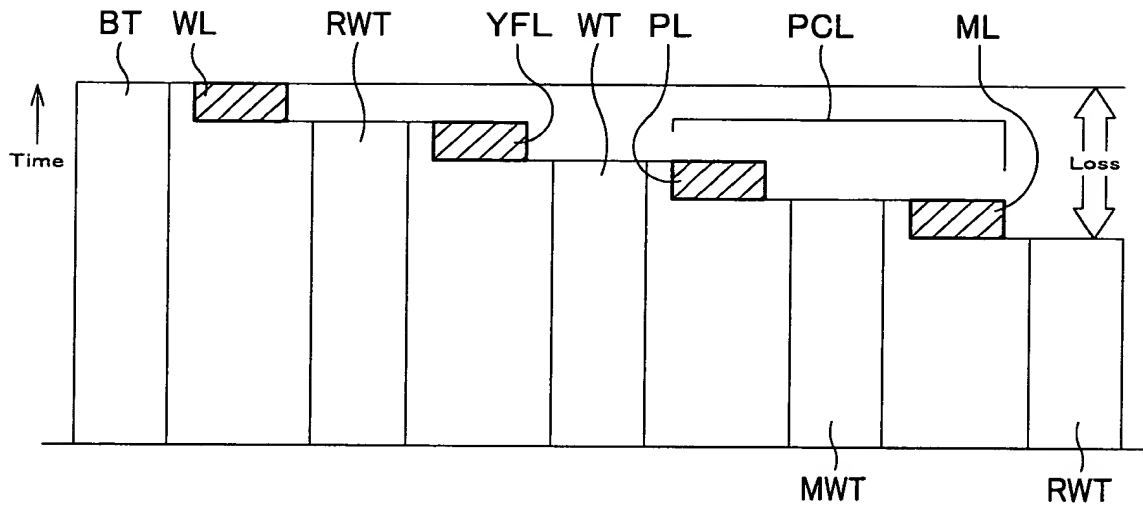
76a	76b	76c	76d	76e	76f	76g	76h	76i	76j	76k	76l	76m	76
SPEC													
1	S2H	N/R	1	FR W/H	211101	T.T	T.T gun	Set	4				
2							SR M/C 1B	Set	18				
3						1ST	SR M/C 1A	Set	12				
4							SR M/C 2A	Set	12				
5							SR M/C 3A	Set	8				
6							SR M/C 1B	Set	9				
7							SR M/C 2B	Set	11				
8							SR M/C 3B	Set	13				
9						2ST	SR M/C 1A	Set	7				
10							SR M/C 2A	Set	7				
11							SR M/C 3A	Set	10				
12							SR M/C 1B	Set	9				
13							SR M/C 2B	Set	14				
14							SR M/C 3B	Set	12				
15						Sub Total			146				
16													

76n

	Class	Change No.	Date	Editor	Content	Changed	Series	Contnet	LineNo	Line	No
1	- E 1	S2HA-F-0001	1998/8/25	812563	Process reduction by spec. change	-2.60	S2H	N/R	1	FR W/H	2 ▲
2											
3											
4											
5											
6											
7											

77d

FIG.42A



09342472, 042601

FIG. 42B

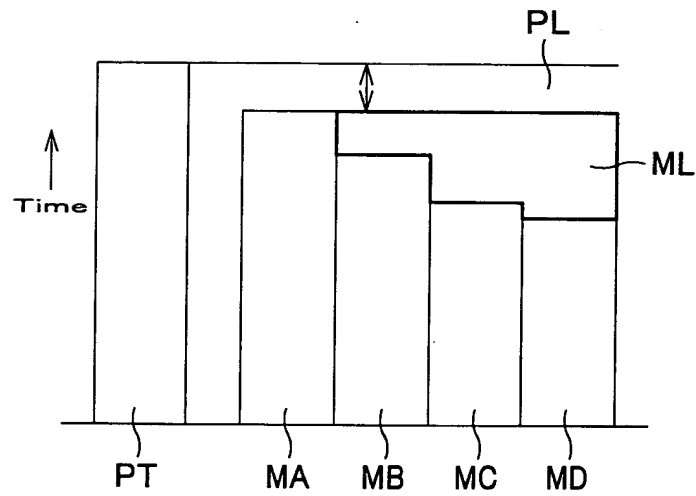


FIG. 42B

FIG. 43

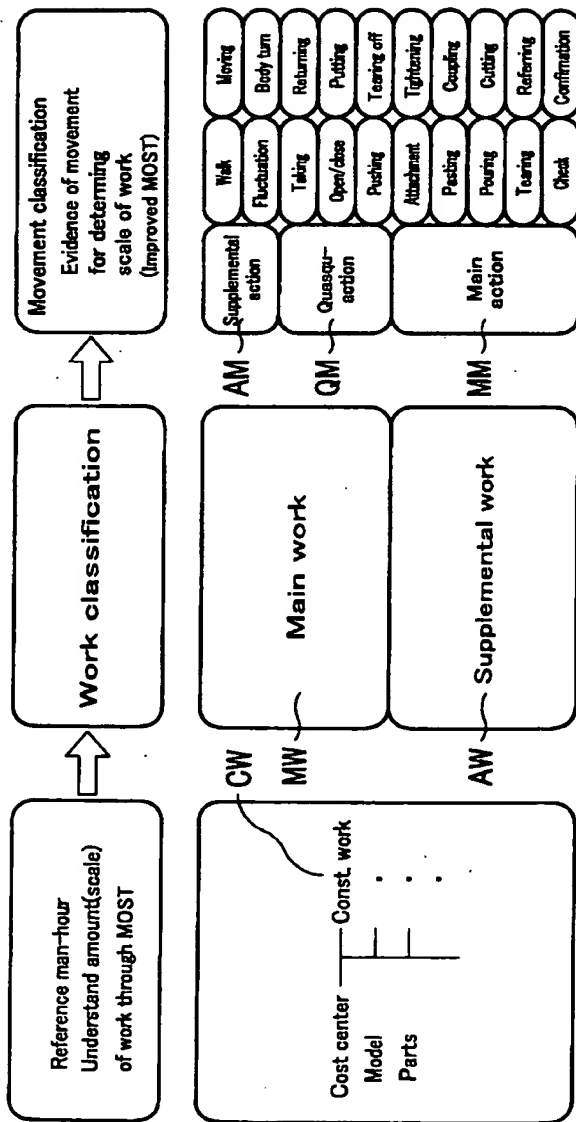


FIG.44

